



Workshop Manual

Fox 2004 ➤

SpaceFox 2006 ➤

General body repairs, exterior

Edition 01.2017





List of Workshop Manual Repair Groups

Repair Group

- 50 - Body - front
- 55 - Bonnet, rear lid
- 57 - Front doors, door components, central locking
- 58 - Rear doors, door components
- 60 - Sunroof
- 63 - Bumpers
- 64 - Glazing
- 66 - Exterior equipment

Technical information should always be available to the foremen and mechanics, because their careful and constant adherence to the instructions is essential to ensure vehicle road-worthiness and safety. In addition, the normal basic safety precautions for working on motor vehicles must, as a matter of course, be observed.



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50 – Body - front

1 Body - front section

(VRL009971; Edition 01.2017)

1.1 Front end with complementary parts - remove and install

Special tools and workshop equipment required

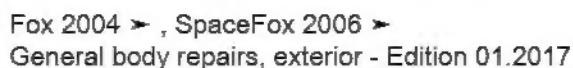
- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



Note

- ◆ *The air conditioning condenser hoses must not be bent.*
- ◆ *The condenser cannot be suspended by the hoses.*





- ☐ 2 units
- ☐ Torque: 8 Nm

☐ Information for removal:

- Remove door latch
⇒ page 19 .
- Remove front bumper and front bumper support ⇒ page 126 .
- Remove the radiator ⇒ Engine; Rep. gr. 19 ; Cooling system - Radiator - remove and install and condenser ⇒ Heating, ventilation, air conditioning; Rep. gr. 87 ; Air conditioning - Condenser - remove and install



When installing, centralize front panel in longitudinal members and between headlight housings.

- ☐ 2 units
- ☐ Torque: 8 Nm

4 - Bumper support

- ☐ 6 units
- ☐ Torque: 35 Nm

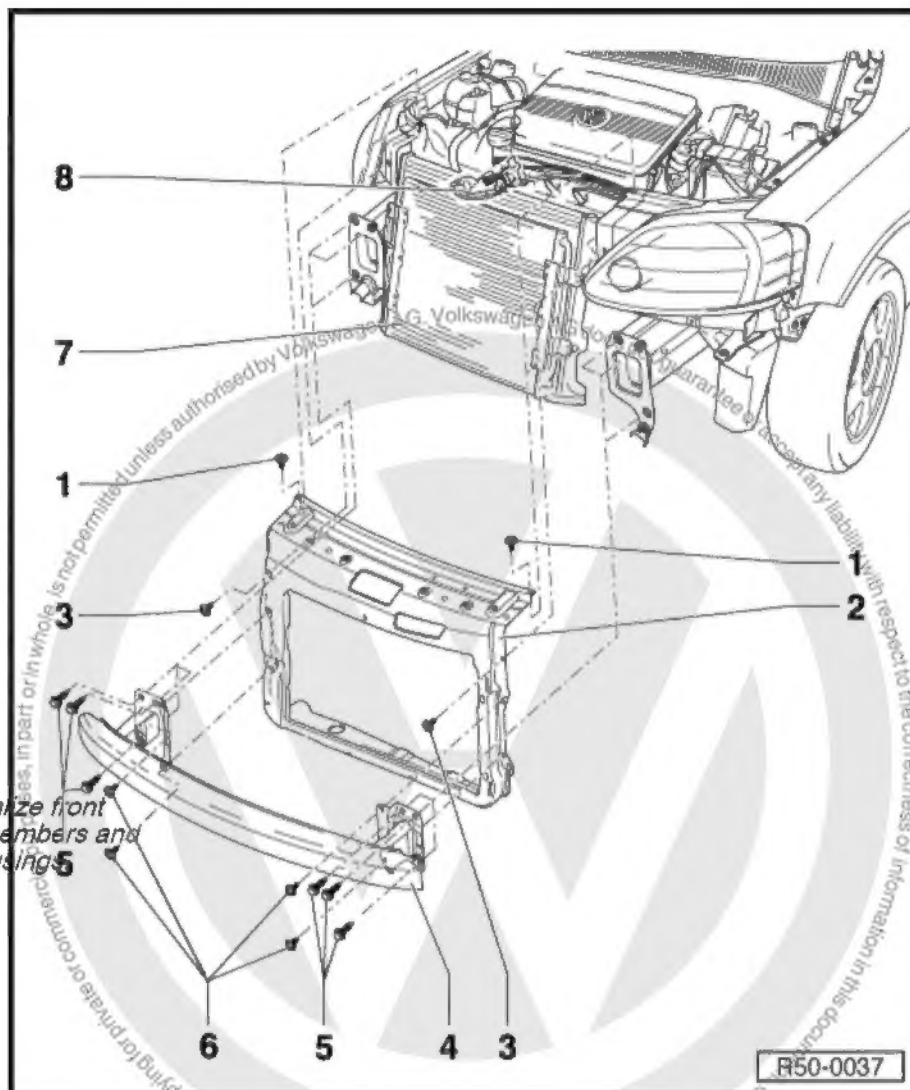
- ☐ 4 units
- ☐ Torque: 8 Nm

7 - Radiator and condenser

- ☐ Remove from front end ⇒ Heating, ventilation, air conditioning; Rep. gr. 87 ; Air conditioning

8 - Bonnet latch

- ☐ Remove ⇒ page 18

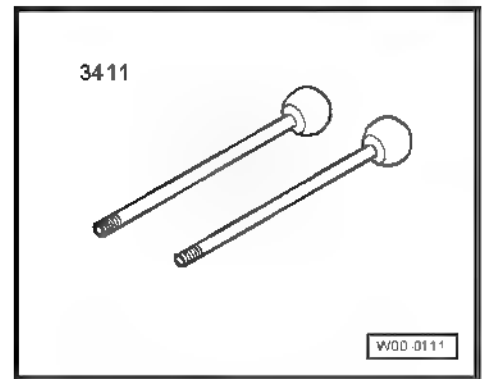


1.2 Front end - service position

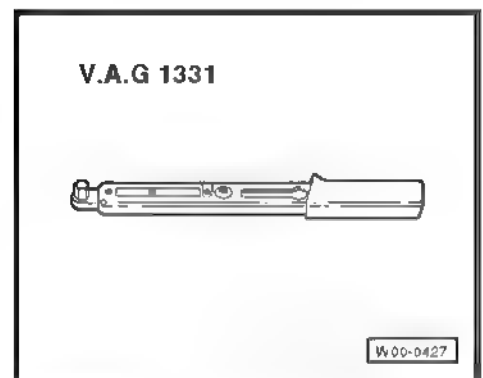
Special tools and workshop equipment required

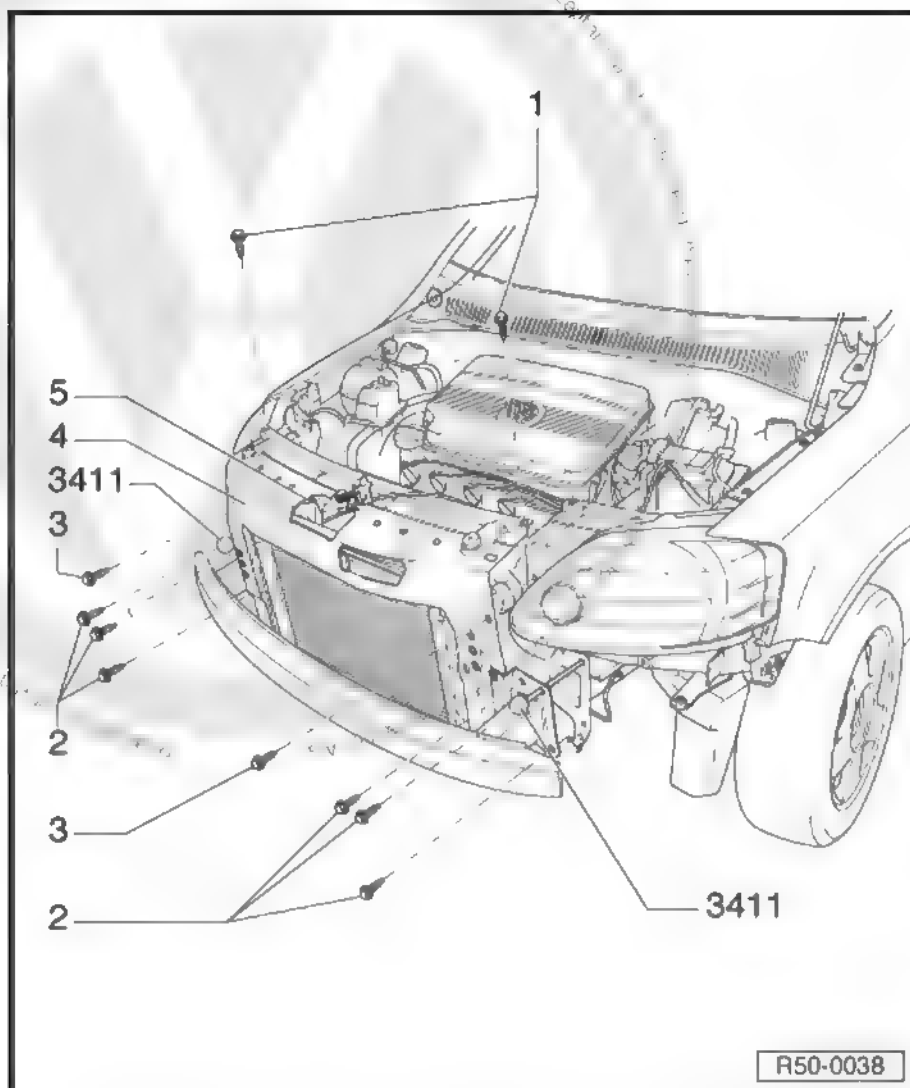


◆ Guide pins - 3411-



◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-





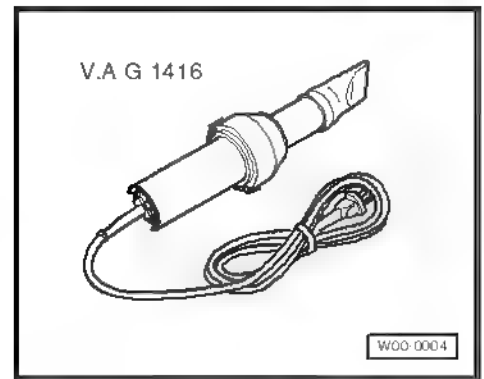
- Remove hood latch -5-.
- Remove the front bumper ⇒ [page 126](#) .
- Release one screw -2- from each side and screw guide pins - 3411- in their places in right and left longitudinal members.
- Remove screws -1- and -3-.
- Remove other screws -2- from the longitudinal members and pull front panel -4- forward in the guide pin - 3411- area.

1.3 Front wing - assembly overview

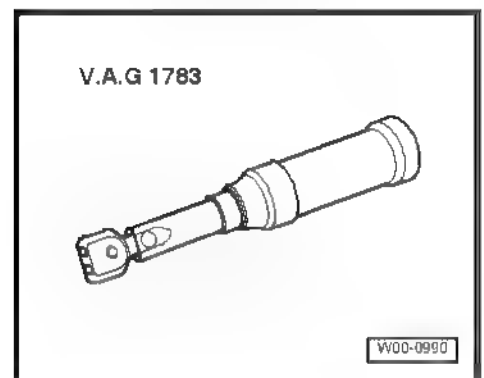
Special tools and workshop equipment required



◆ Hot air blower - VAG 1416-



◆ Torque wrench 2 to 10 Nm - VAG 1783-





1 - Wing

☐ Information for removal:

- Remove the front bumper ➔ [page 126](#) .
- Remove the wheel arch protector ➔ [page 253](#) .
- If necessary, heat and remove the wing at the A-pillar area with the hot air blower - VAG 1416- .



Note

When installing, before fastening the wing, a coat of zinc-based conductive paint must be applied ➔ [Painting Manual - Anticorrosion protection measures - Materials for anticorrosion protection before mounting - Zinc-based conductive paint or -AKL 381 035 50-](#) to the contact area of each bumper mounting point.

2 - Bolt

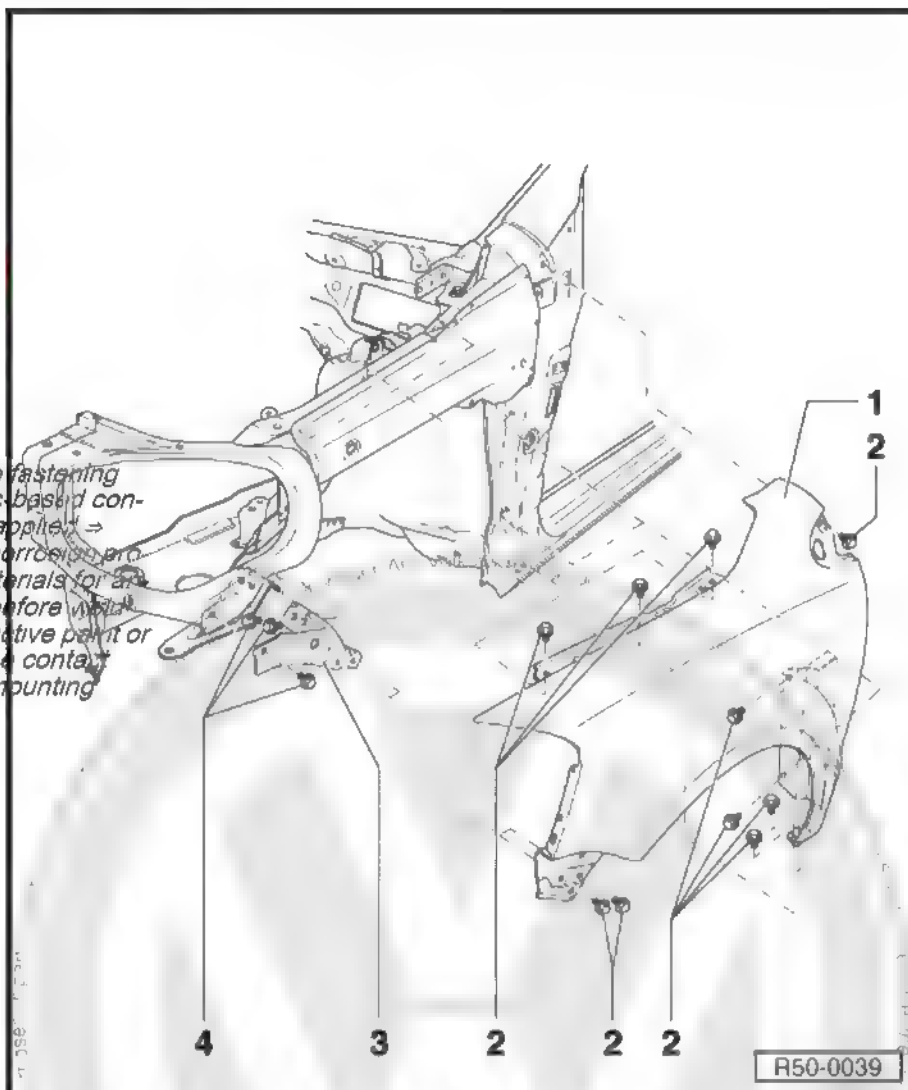
- ☐ Torque: 6 Nm
- ☐ 10 units

3 - Mounting bracket

- ☐ fastened with screws to the wheel arch

4 - Bolt

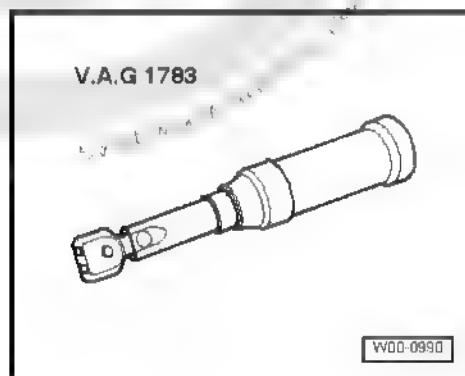
- ☐ Torque: 6 Nm
- ☐ 3 units



1.4 Noise insulation (petrol engine) - assembly overview

Special tools and workshop equipment required

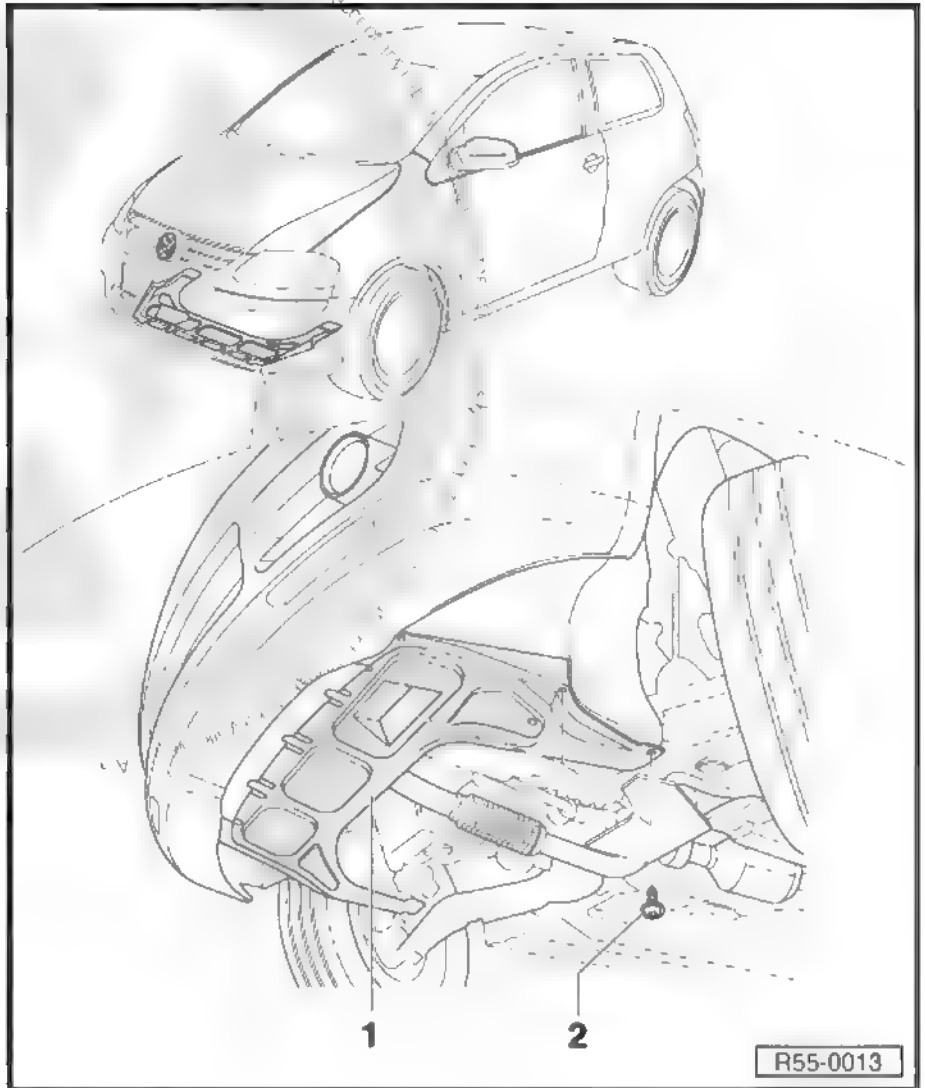
- ◆ Torque wrench 2 to 10 Nm - VAG 1783





1 - Noise insulation

- ☐ fastened to and fitted in the front section of front panel
- ☐ 9BWLB45Z994023857 (►05 08) , last Brazilian vehicle with noise insulation
- ☐



WVWZZZ5ZZB4184311 (►07.11) , last European vehicle with noise insulation

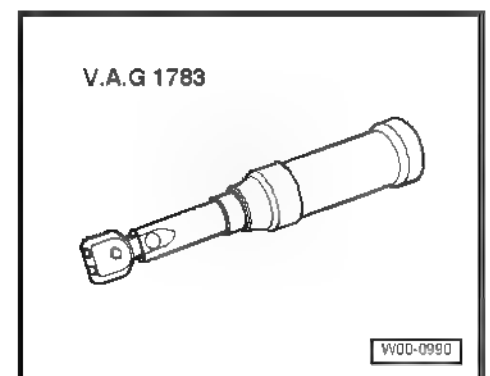
2 - Bolt

- ☐ Torque: 6 Nm
- ☐ 6 units

1.5 Noise insulation (diesel engine) - assembly overview

Special tools and workshop equipment required

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-





1 - Bolt

- ☐ 9 units
- ☐ Torque: 2.5 Nm

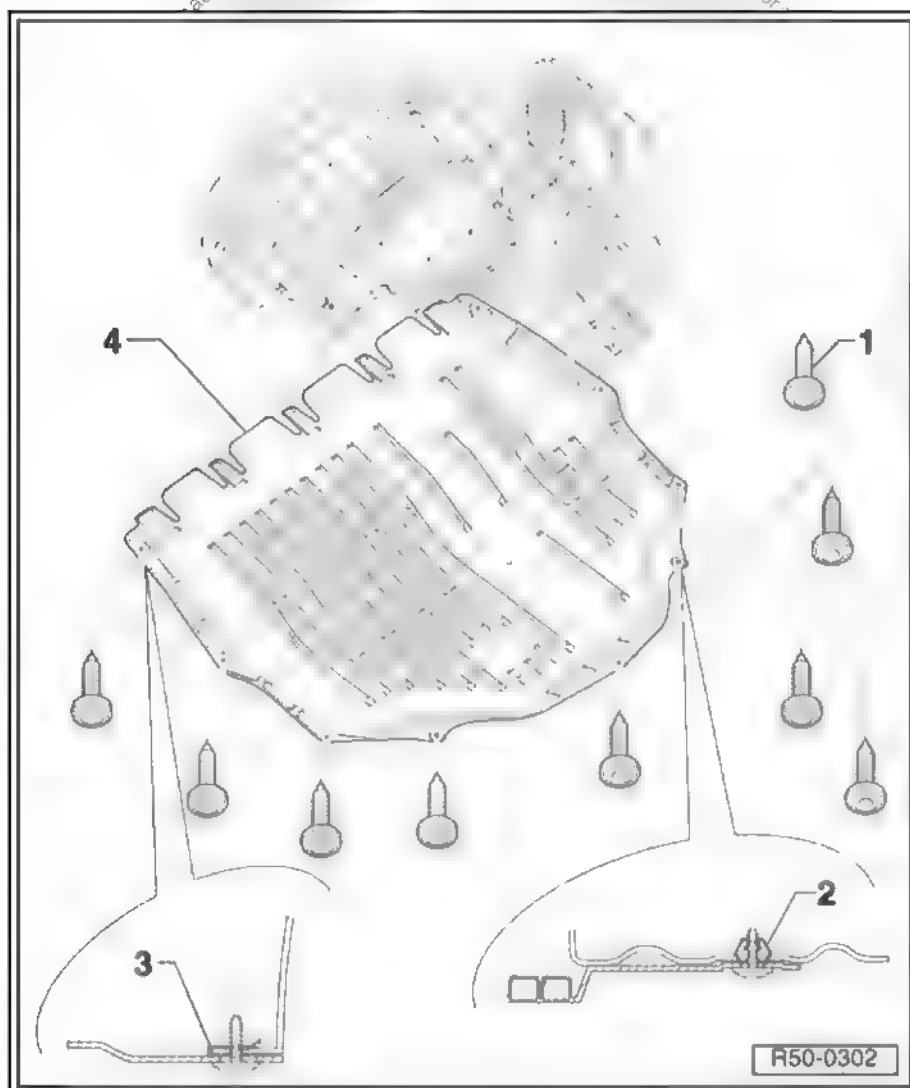
2 - Bushing

- ☐ replace if necessary

3 - Speed nut

4 - Noise insulation

- ☐ for diesel engines
- ☐ fastened to and fitted in the front section of front panel


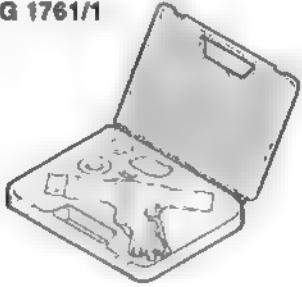
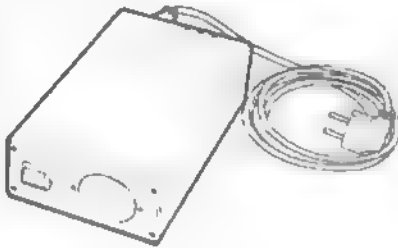




2 Bulkhead

2.1 Tools

Special tools and workshop equipment required

<p>V.A.G 1331</p> 	<p>V.A.G 1761/1</p> 
<p>V.A.G 1939</p> 	
	<p>Q50-10001</p>

- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-
- ◆ Cartridge heater - VAG 1939A-
- ◆ Pneumatic Adhesive applicator for glued glasses - VAG 1761/1- or Adhesive applicator for glued glasses - VAG 1628-

2.2 Auxiliary materials for Brazilian market



WARNING

- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*



- ◆ PU 1K Adhesive Betaseal U 400 HV - ➤
Chemicals Manual;
Rep. gr. 00 ; Chemicals
Manual - List of author-
ized products ^{1, 2}
- ◆ Body Primer Betaprime 5404 - ➤
Chemicals Manual;
Rep. gr. 00 , Chemicals
Manual - List of author-
ized products ¹
- ◆ Cleaning solution D 009 401 04 ¹

1) Observe the procedural indications in accordance with the manufacturer's pre-
scriptions for packaging disposa

2) Follow the minimum curing time ➤ [page 11](#) .

2.3 Auxiliary materials for export market



WARNING

- ◆ *When handling chemicals follow the safety instructions ➤
Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➤ Electronic Parts
Catalogue "ETKA"*

- ◆ PU 1K Adhesive DH 009 100 (300 ml) ^{1, 2, 3}
- ◆ Glass and painting primer D 009 200 02 ¹
- ◆ Cleaning solution D 009 401 04 ¹
- ◆ Primer applicator D 009 500 25

3) Observe the procedural indications in accordance with the manufacturer's pre-
scriptions for packaging disposa

4) Heat up them according to manufacturer instructions Cartridge heater - VAG
1939A-

5) Respect minimum curing time ➤ [page 11](#)

2.4 Matching table



WARNING

- ◆ *When handling chemicals follow the safety instructions ➤
Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➤ Electronic Parts
Catalogue "ETKA"*



Note

To help understanding, please find below a comparison table for
materials used in the Brazilian and export markets

Product	Brazilian Market	Export Market
PU Adhesive	Betaseal U-400 HV	DH 009 100 (300 ml)



Product	Brazilian Market	Export Market
Body primer	Betaprimer 5404	D 009 200 02

2.5 Engine compartment partition panel - assembly overview



Note

The engine compartment partition panel -1- is also fastened with polyurethane adhesive (PUR) -3-

1 - Bulkhead

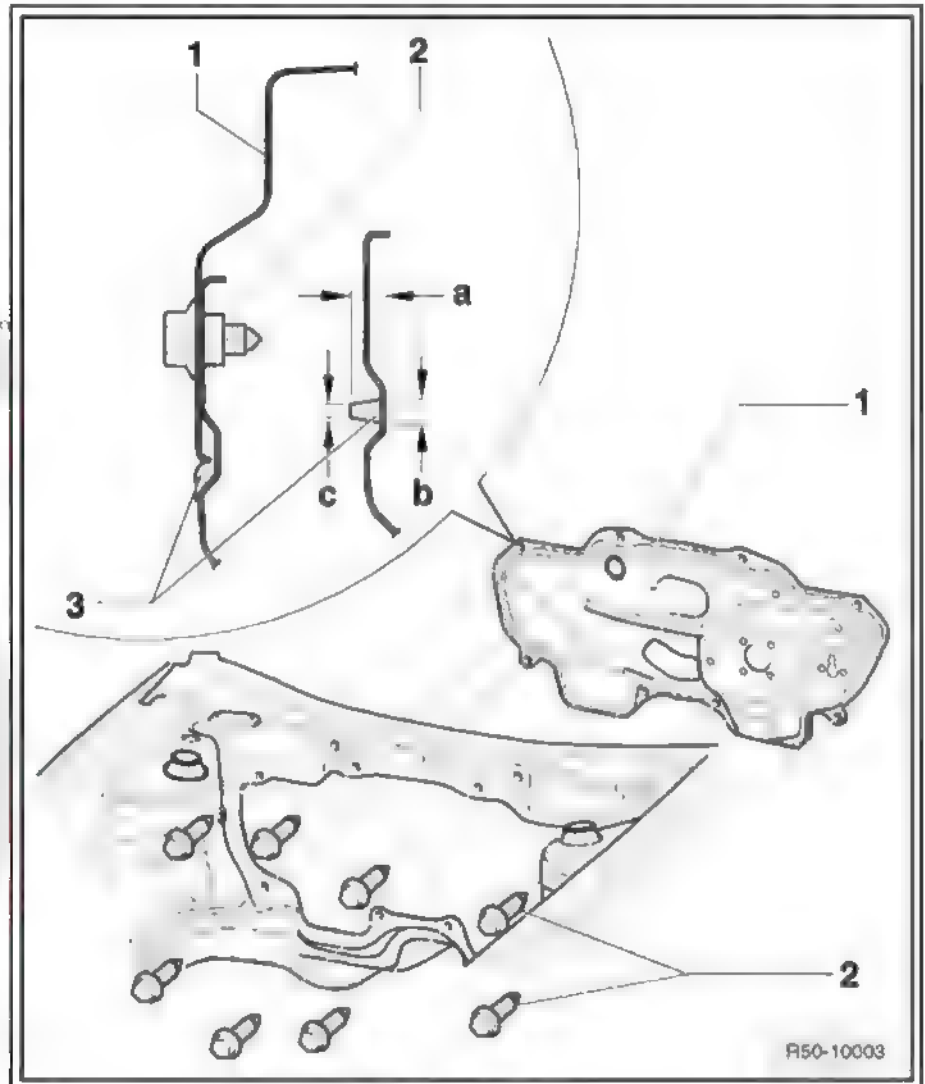
- ☐ remove:
- After the screws are removed -2-, cut the adhesive cord.

2 - Bolt

- ☐ 8 units
- ☐ Torque: 25 Nm

3 - PUR adhesive

- ☐ Auxiliary materials Brazilian market ➔ [page 9](#)
- ☐ Auxiliary materials for the export market ➔ [page 10](#)
- ☐ Sealant bead section:
-a- = 11 mm, -b- = 8.5 mm, -c- = 7 mm
- ☐ Minimum curing time ➔ [page 11](#)



2.6 Minimum adhesive drying time

Minimum curing time is the time from panel gluing to vehicle usage. During this time, the vehicle must remain on a flat surface and at room temperature (at least 59 °F).



Note

The vehicle may be delivered to client 3 hours after repair, minimum.



3 Engine compartment upper partition panel

3.1 Engine compartment upper partition panel - assembly overview



Note

The engine compartment upper partition panel -1- is fastened also with polyurethane adhesive (PUR) -3-.

1 - Engine compartment upper partition panel

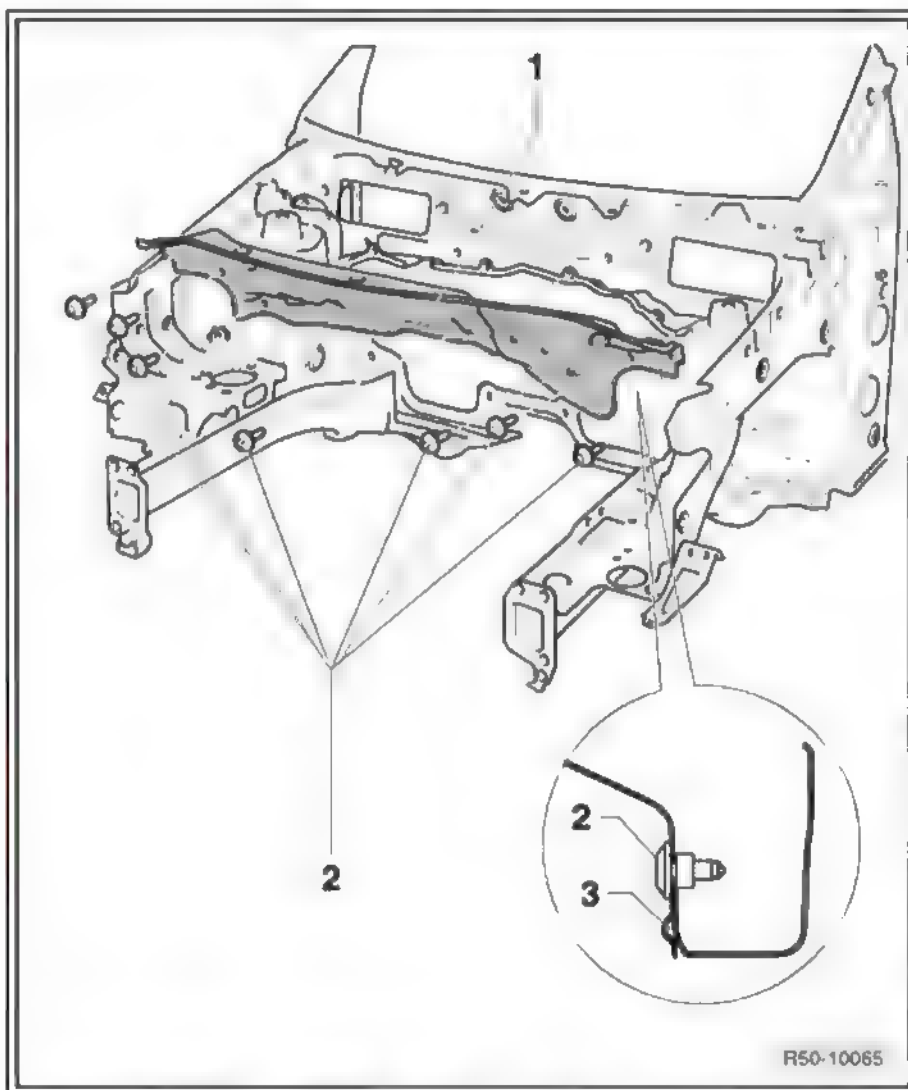
- ☐ remove:
- After the screws are removed -2-, cut the adhesive cord.

2 - Bolt

- ☐ 8 units
- ☐ Torque: 25 Nm

3 - PUR adhesive

- ☐ Auxiliary materials Brazilian market ⇒ [page 9](#)
- ☐ Auxiliary materials for the export market ⇒ [page 10](#)
- ☐ Minimum curing time ⇒ [page 11](#)



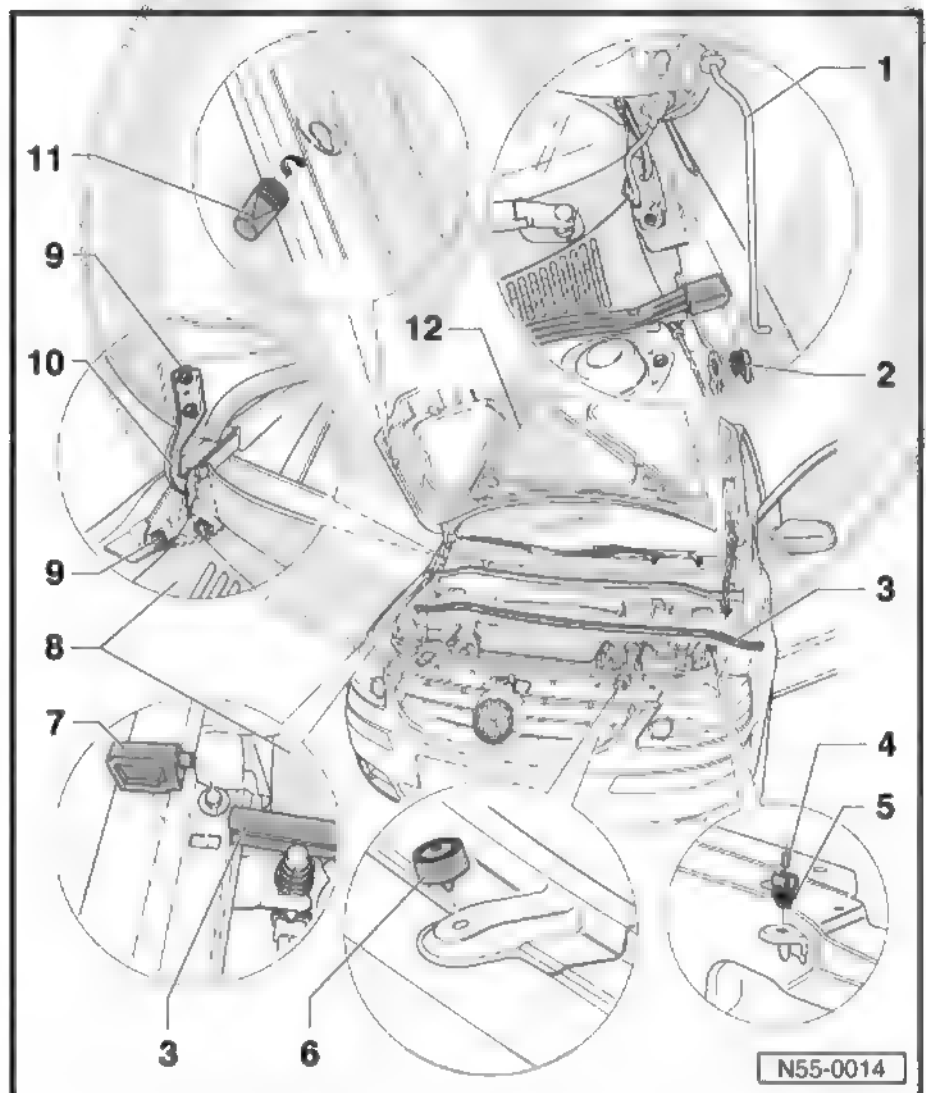


55 – Bonnet, rear lid

1 Bonnet

1.1 Bonnet - assembly overview

- 1 - Bonnet supporting rod
- 2 - Bushing
- 3 - Bonnet trim
 - ☐ fitted onto the flange
- 4 - Expansion pin
- 5 - Fastening clip
 - ☐ for bonnet supporting rod
- 6 - Striker
- 7 - Stuffing
- 8 - Lower windscreen covering
 - ☐ Remove and install
- 9 - Bolt
 - ☐ 4 pieces per hinge
 - ☐ Torque: 23 Nm
- 10 - Hinge
- 11 - Adjustment buffer
 - ☐ the bonnet can be adjusted in the height in relation to the wing by threading or unthreading it
- 12 - Bonnet
 - ☐ Remove:
 - Remove pipes for windscreen washer and nozzles.
 - Loose screws -9- of front bonnet, and remove the bonnet



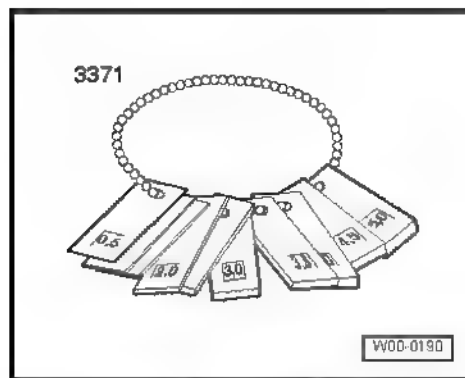
- Check latch distance from locking hook in front bonnet: "a" should be ≥ 7 mm
- ☐ Adjust ➔ [page 13](#)

1.2 Bonnet - adjust

Special tools and workshop equipment required



◆ Adjustment gauge - 3371-



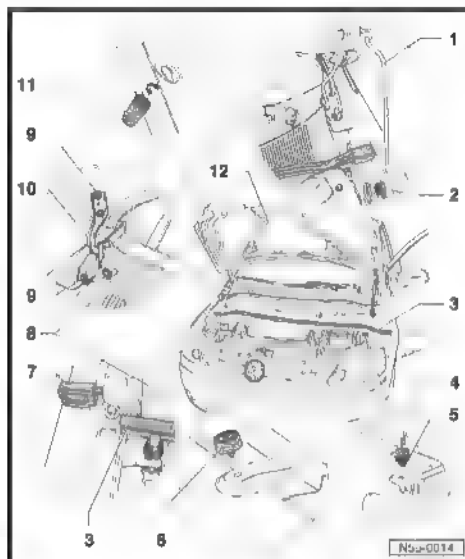
- The bonnet can be aligned between the wings by moving the bonnet hinges in the elongated holes.
- Through the adjustment buffers -11-, the bonnet can be adjusted for height in respect to the wing panels.
- Clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .



Note

Check front bonnet latch alignment dimension "a" with locking hook ⇒ [page 18](#)

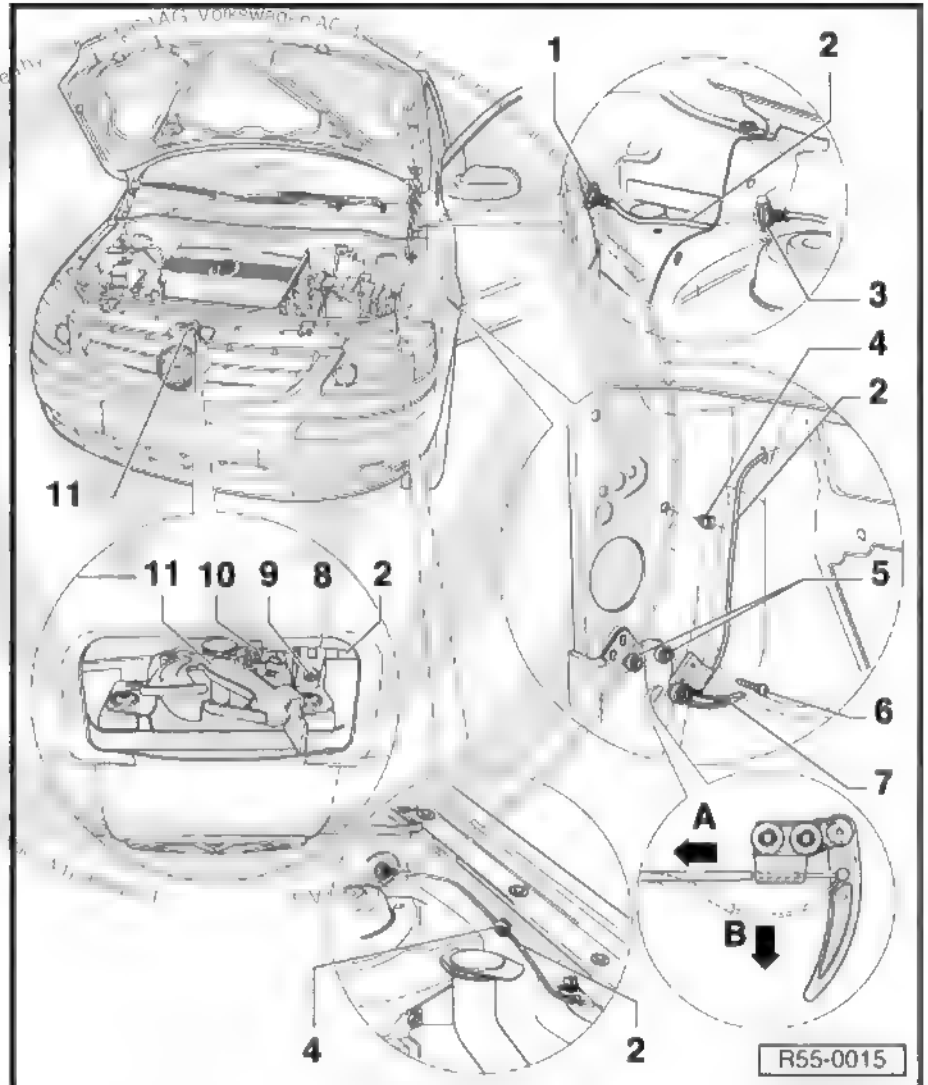
- After assembly or adjustment works, the following measures must be taken for protection against corrosion in hinges and screws.



1.3 Latch operation cable - assembly overview



- 1 - Sealing bellows
 - ☐ From plenum chamber to interior compartment
- 2 - Operating cable
 - ☐ Remove and install
➔ [page 15](#)
- 3 - Sealing bellows
 - ☐ from engine compartment to water deflector panel.
- 4 - Operating cable fastening clamp
 - ☐ 2 units
- 5 - Distance bushing
 - ☐ 2 units
- 6 - Bolt
 - ☐ 2 units
 - ☐ Torque: 1.5 Nm
- 7 - Actuating lever
 - ☐ with support
- 8 - Clamp
 - ☐ for operating cable
- 9 - Bolt
 - ☐ 3 Nm
- 10 - securing bolt
 - ☐ for cable
 - ☐ Torque: 3 Nm
- 11 - Front bonnet latch
 - ☐ Assembly overview
➔ [page 18](#)
 - ☐ Remove and install front bonnet latch ➔ [page 19](#)

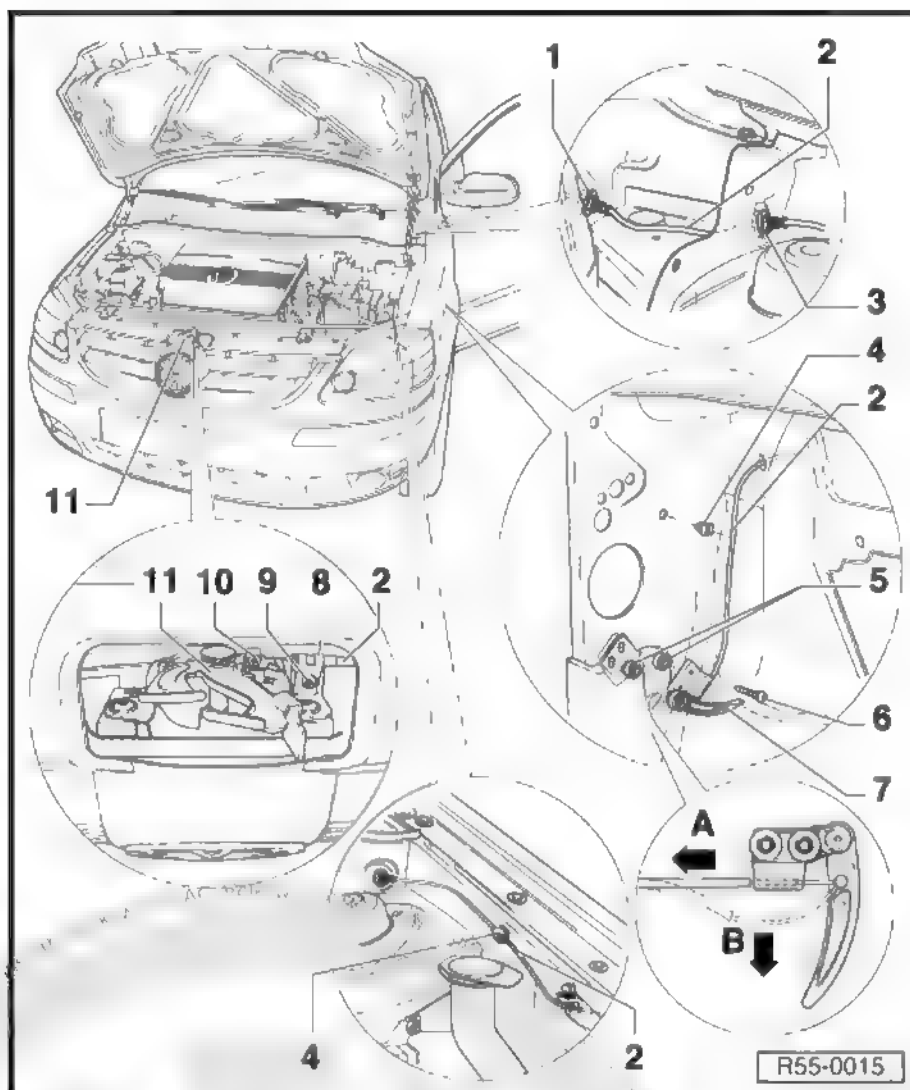


1.4 Latch operating cable - remove and install



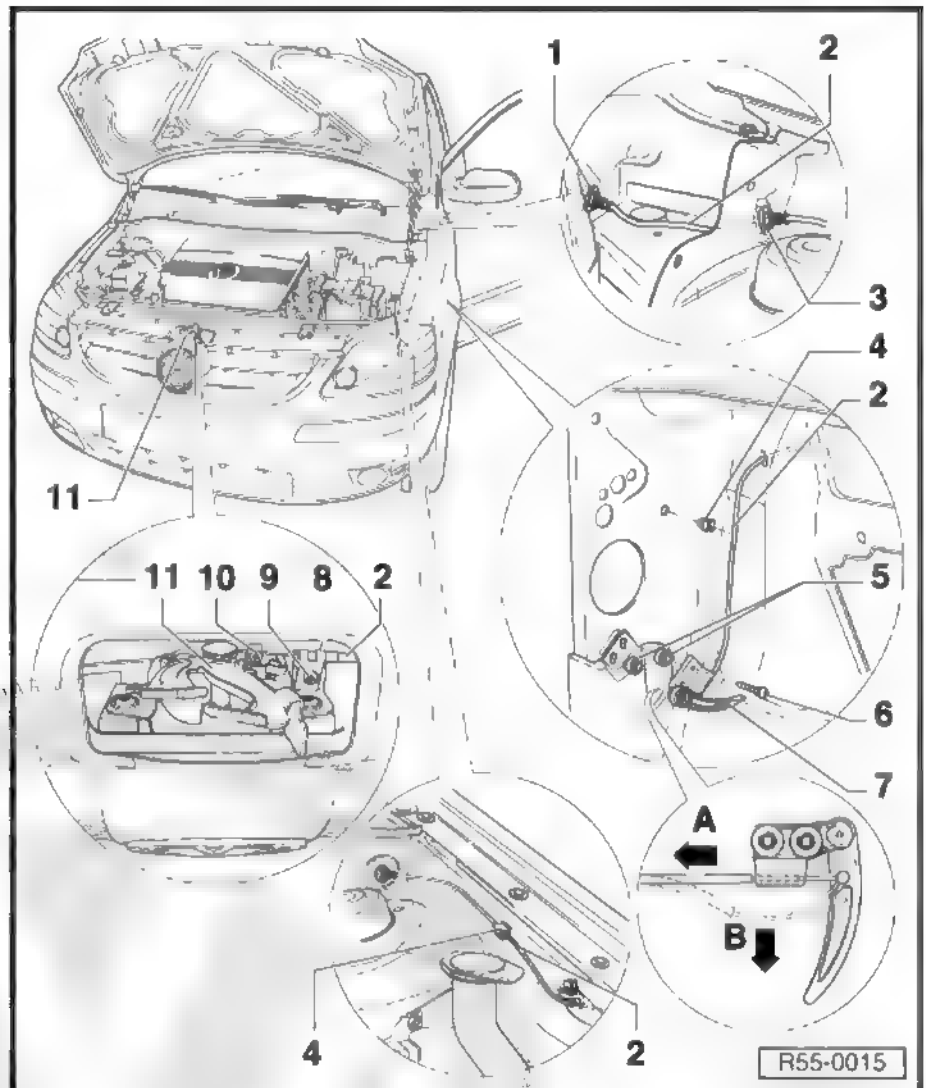
Note

While the operating cable is not fully installed, under no circumstances the bonnet can be closed, otherwise the bonnet latch will be locked and, without the operating cable installed, it cannot be opened again.



Remove

- Disengage the Onboard supply control unit - J519- and its support. Disengage relay plate and put it aside; afterwards, remove the three screws fastening the support to the relay plate.
- Remove lower windscreen lining.
- Release the fastening screw -10- from the bonnet latch -11- and, if necessary, straighten the operating cable tip -2-.
- Release fastening screw -9- from clamp -8- and pull operating cable off.
- Remove fastening screws -6- from operating lever -7- and disengage operating lever from side wall
- Pull operating lever operating cable cover -2- out of seating in support -arrow A- and remove cable.
- Turn operating cable -arrow B- and remove it from seating in operating lever.
- Loosen sealing bellows -1- and -3- from fastening clamps -4- on the side of the partition wall and operating cable -2-.
- Pull operating cable -2- in direction of engine compartment



Install

Install is performed in the reverse sequence, observing the following:

- Place the sealing bellows -1- and -3- onto the new operating cable.



Note

Arrange correct sealing bellows seating in order to avoid leakage.

- Pass operating cable through bonnet latch -11-, in this case, the operating cable bushing must be completely pushed into clamp -8-. Tighten fastening screw -9- to 3 Nm.
- In order to adjust operating cable, operating lever -7- must be completely pressed forward and then fastening screw -10- must be tightened in bonnet latch -11- to 3 Nm.
- Check whether latch activation and opening mechanism operation is OK. Lastly, fold remaining cable tip

1.5 Bonnet hinge - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

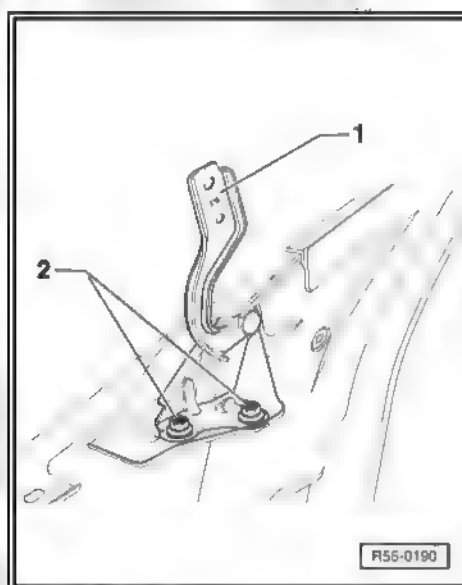
V.A.G 1331



W00-0427

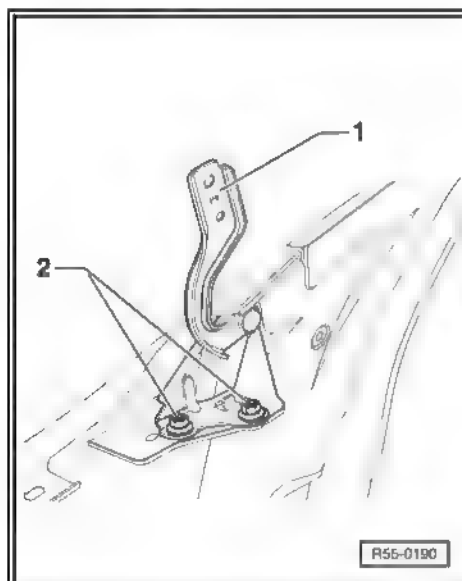
1.5.1 Remove

- Remove bonnet ⇒ [page 13](#) .
- Remove the screws -2- for fastening the hinge -1-.



1.5.2 Install

- Install the hinge -1-.
- Torque of screws -2-. 24Nm.
- Install bonnet.



1.6 Front bonnet latch - assembly overview



1 - Locking hook

- ☐ fastened with front bonnet
- ☐ check locking hook distance from latch in front bonnet: "a" should be ≥ 7 mm

2 - Front bonnet latch

- ☐ Remove and install
 [⇒ page 19](#)
- ☐ Adjust: through elongated holes
- ☐ Check latch distance from locking hook in front bonnet: "a" should be ≥ 7 mm
- ☐ Clearance dimensions
 \Rightarrow Body Repairs; Rep. gr. 00; Technical data - Body clearance dimensions .

3 - Bolt

- ☐ 2 units
- ☐ Torque: 8 Nm

4 - Clamp

- ☐ For operating cable

5 - Operating cable

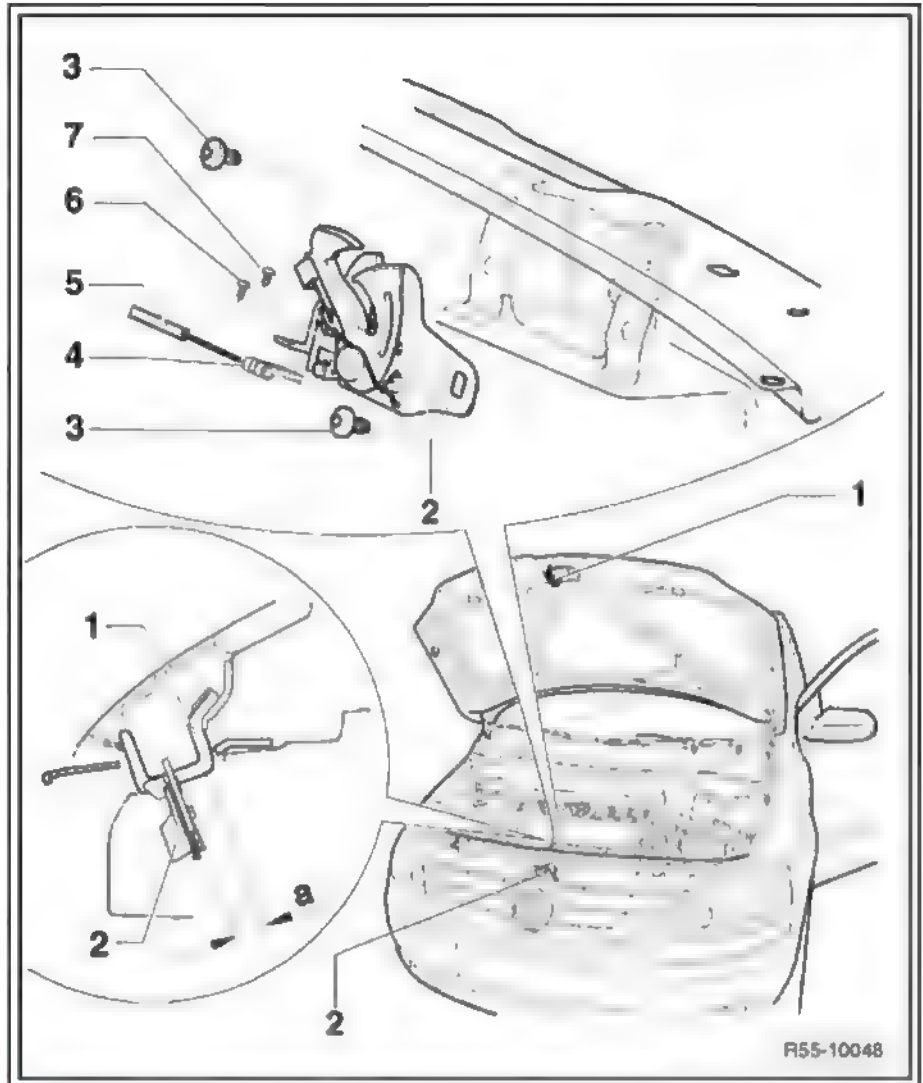
- ☐ Remove and install
 [⇒ page 15](#)

6 - Bolt

- ☐ Torque: 3 Nm

7 - securing bolt

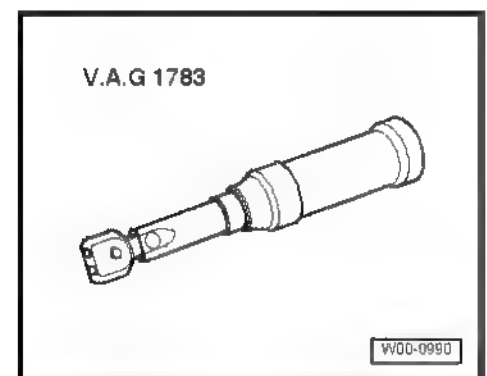
- ☐ for cable
- ☐ Torque: 3 Nm



1.7 Bonnet latch - remove and install

Special tools and workshop equipment required

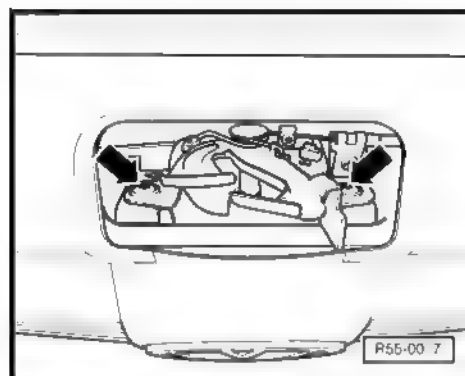
- ◆ Torque wrench 2 to 10 Nm - VAG 1783-



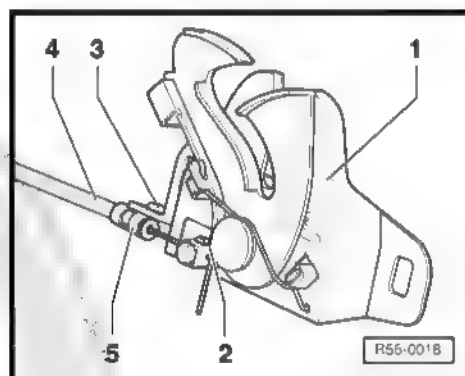


Remove

- Unscrew screws -arrows- and pull bonnet latch out of front panel in direction of engine compartment.

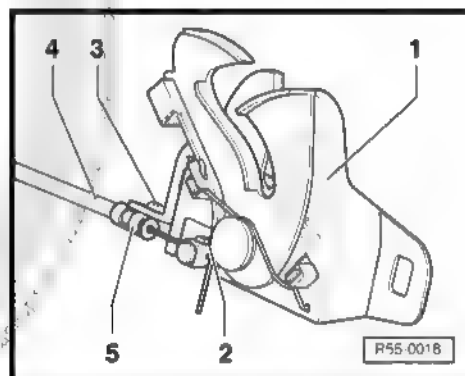


- Loosen fastening screw -2- from operating cable -4- and, if necessary, unfold operating cable end.
- Unscrew fastening screw -3- from clamp -5- and remove operating cable -4- from bonnet latch -1-.



Install

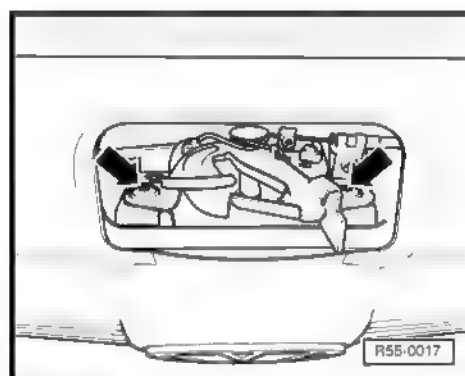
- Pass operating cable through bonnet latch -1-; in this case, operating cable bushing -4- must be completely pushed in clamp -5-.
- Tighten fastening screw -3- to 3 Nm.
- In order to adjust operating cable, operating lever ⇒ [item 7 \(page 15\)](#) must be completely pressed forward and then fastening screw -2- must be tightened in bonnet latch -1- with 3 Nm.
- Check whether latch activation and opening mechanism operation is OK. Lastly, fold remaining cable tip.
- Place bonnet latch on front panel through the side of the engine compartment, and manually tighten screws -arrows-.



Note

Check front bonnet latch alignment dimension "a" with locking hook ⇒ [page 18](#)

- Check clearance dimensions and adjust bonnet latch through elongated holes if necessary ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- Fasten fastening screws -arrows- with final tightening of 8 Nm.





2 Rear lid (Fox)

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

V.A.G 1331



W00-0427

2.1 Assembly overview



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Draining membrane

2 - Adjustment buffer

- Adjust ➔ [page 27](#)

3 - Rear lid shock absorber

- Remove and install ➔ [page 23](#)
- Replace ➔ [page 23](#)
- Lubricate eyelets with lubricating grease - G 052 745 A3-

4 - Threaded pin

- from chassis 94065214
- Torque: 21 Nm

5 - Bolt

- 2 units
- Torque: 8 Nm

6 - Rear lid buffer

- Remove rear panel lining for access ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Adjust: through elongated holes
- Clearance dimensions ➔ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .

7 - Rear lid trim

- Remove and install ➔ [page 23](#)

8 - Hexagonal nut

- Torque: 24 Nm

9 - Bolt

- Torque: 10 Nm

10 - Hinge

- Remove and install ➔ [page 26](#)

11 - Additional brake light

- Removing and installing ➔ **Electrical system**; Rep. gr 94 ; Switches, lights, and external lamps

12 - Rear lid

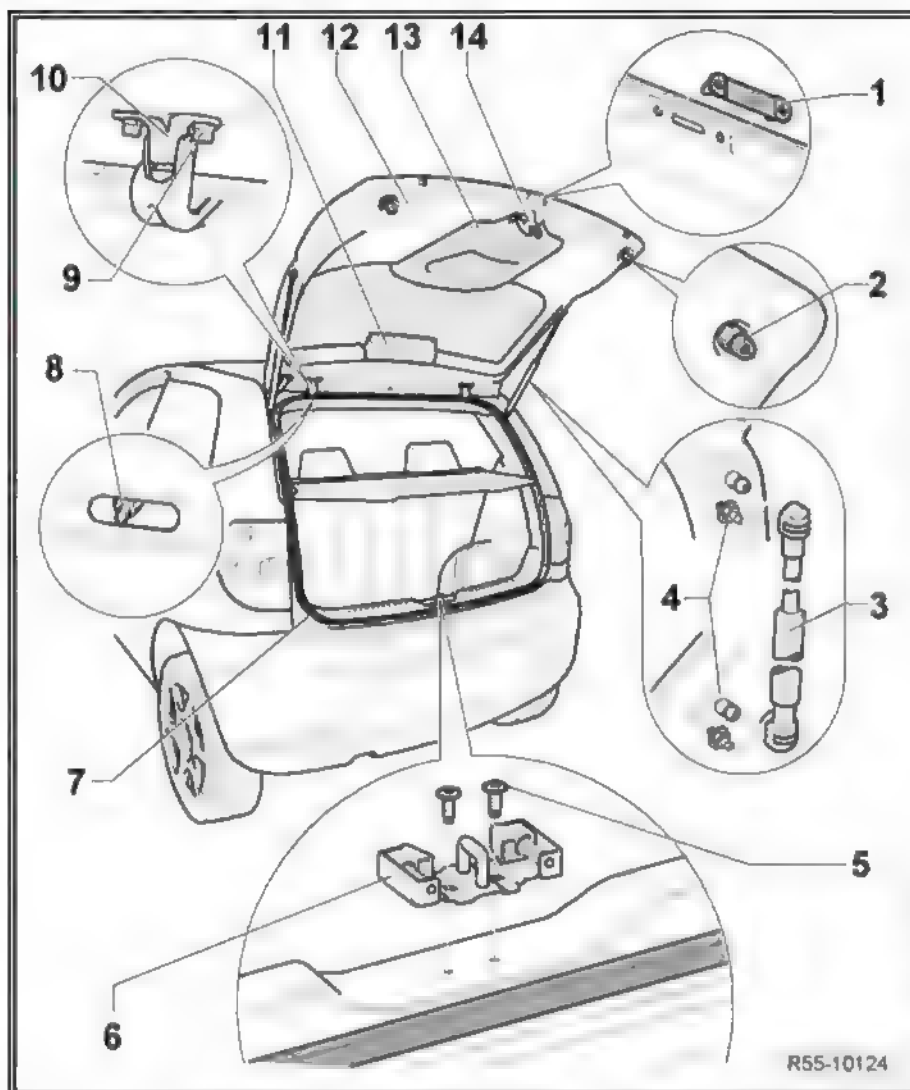
- Remove and install ➔ [page 25](#)
- Adjust ➔ [page 27](#)
- Clearance dimensions ➔ **Body Repairs**; Rep gr 00 ; **Technical data - Body clearance dimensions**.

13 - Lining

- remove and install ➔ **General body repairs, interior**; Rep. gr. 70 , **Linings / insulations**

14 - Rear door latch

- Remove and install ➔ [page 29](#)





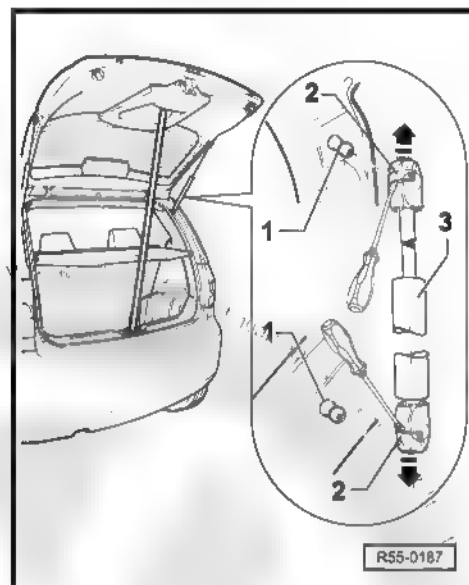
2.2 Rear door shock absorber - remove and install

- Support the rear lid
- Place a small screwdriver underneath the spring clip -2-
- Raise the clip -2- enough to allow the clip to move over the ball joint housing in the -direction of arrow-.
- Pull the gas shock absorber -3- from the joint pins -1-.
- After removing the shock absorber -1-, move the clip -2- back immediately.



Note

Be careful when installing the shock absorber. The clip -2- cannot be completely disengaged from the ball joint housing; otherwise, it will be damaged. If the shock absorber fastening is damaged, there is the risk of accident or personal injury.



2.3 Rear door shock absorber - replace

- Fasten the gas shock absorber to the vise, in area x = 50 mm.



DANGER!

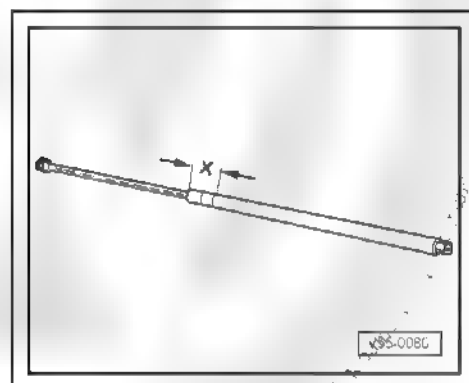
The fastening can only be performed in this area, otherwise there is risk of accident!

- Saw the gas shock absorber cylinder on the first third of its full length, from the reference corner on the plunger rod side.



Note

- ◆ Wear safety goggles when cutting with the saw.
- ◆ The cutting area must be covered with a cleaning cloth.
- ◆ Oil and the cleaning cloth must be duly discarded.



2.4 Rear lid trim - remove and install



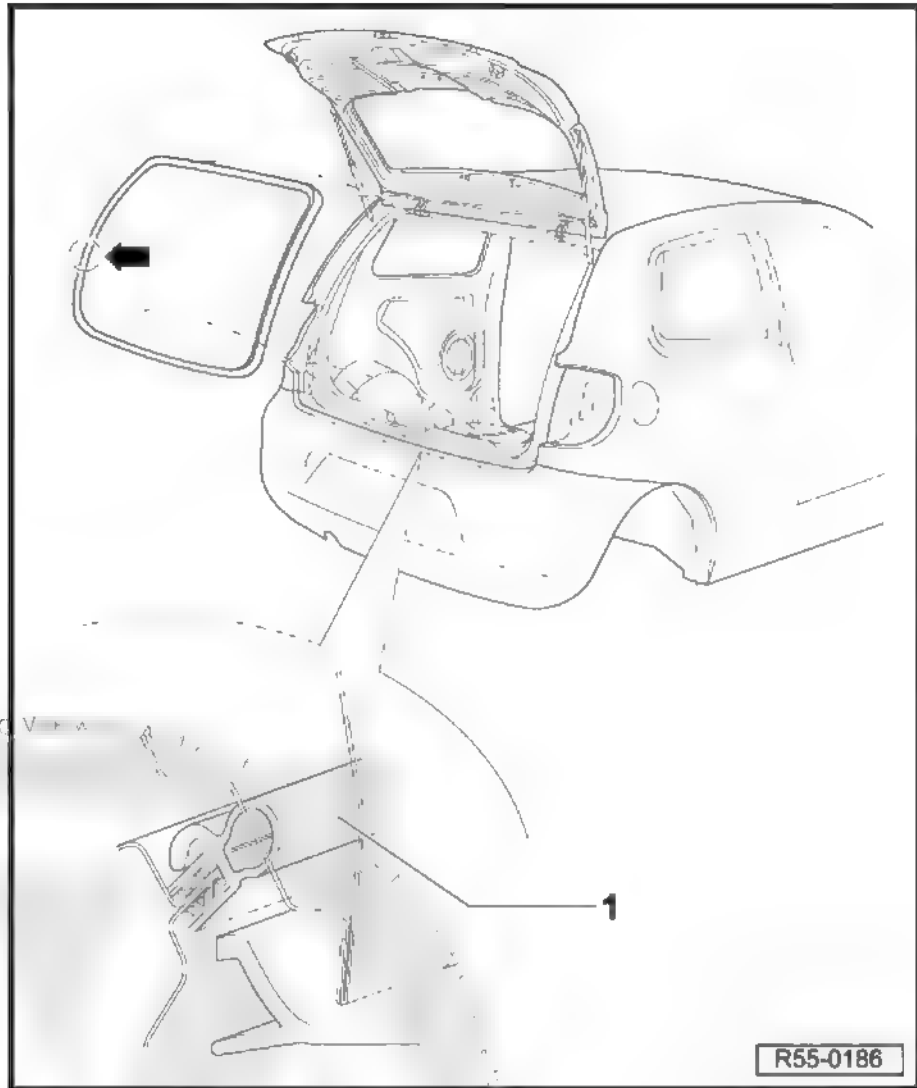
Note

- ◆ For partially removed packing, it is necessary to press packing sides before assembly.
- ◆ New part installation shall be carried out by slightly tapping with a rubber hammer



1 - Additional seal

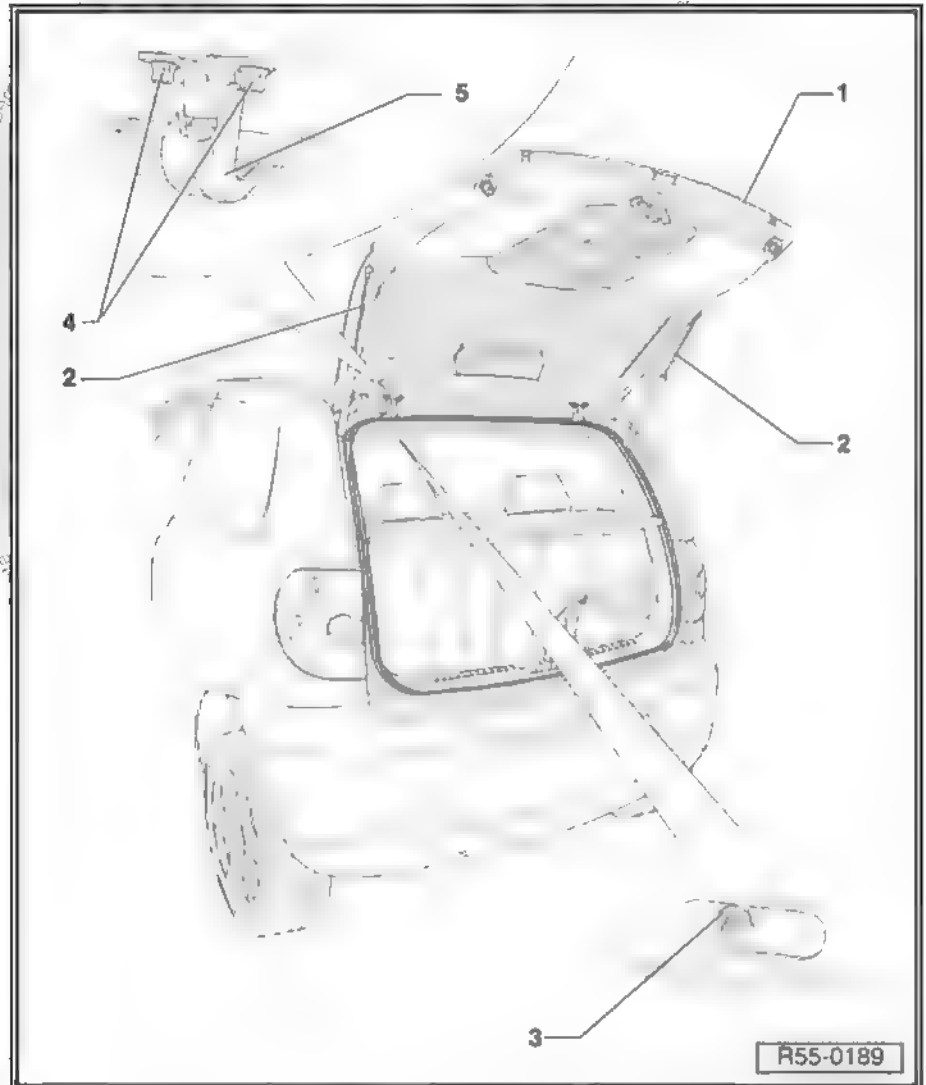
- ☐ start with the flange next to the left rear light to install packing -arrow-





2.5 Rear lid - remove and install

2.5.1 Remove



- Open rear door -1-.
- Remove the rear lid lining ⇒ General body repairs, interior;
Rep. gr. 70 ; Lining / insulation .
- Disengage electric connections and the rear window washer
hose.
- Remove electric harnesses from door.
- Release the bolts -4- from hinge -5-

For the items below, you will need the help of an assistant.

- Remove the rear door shock absorber rod -2- from the rear
door -1-
- Remove the screws -4- and remove the lid

2.5.2 Install

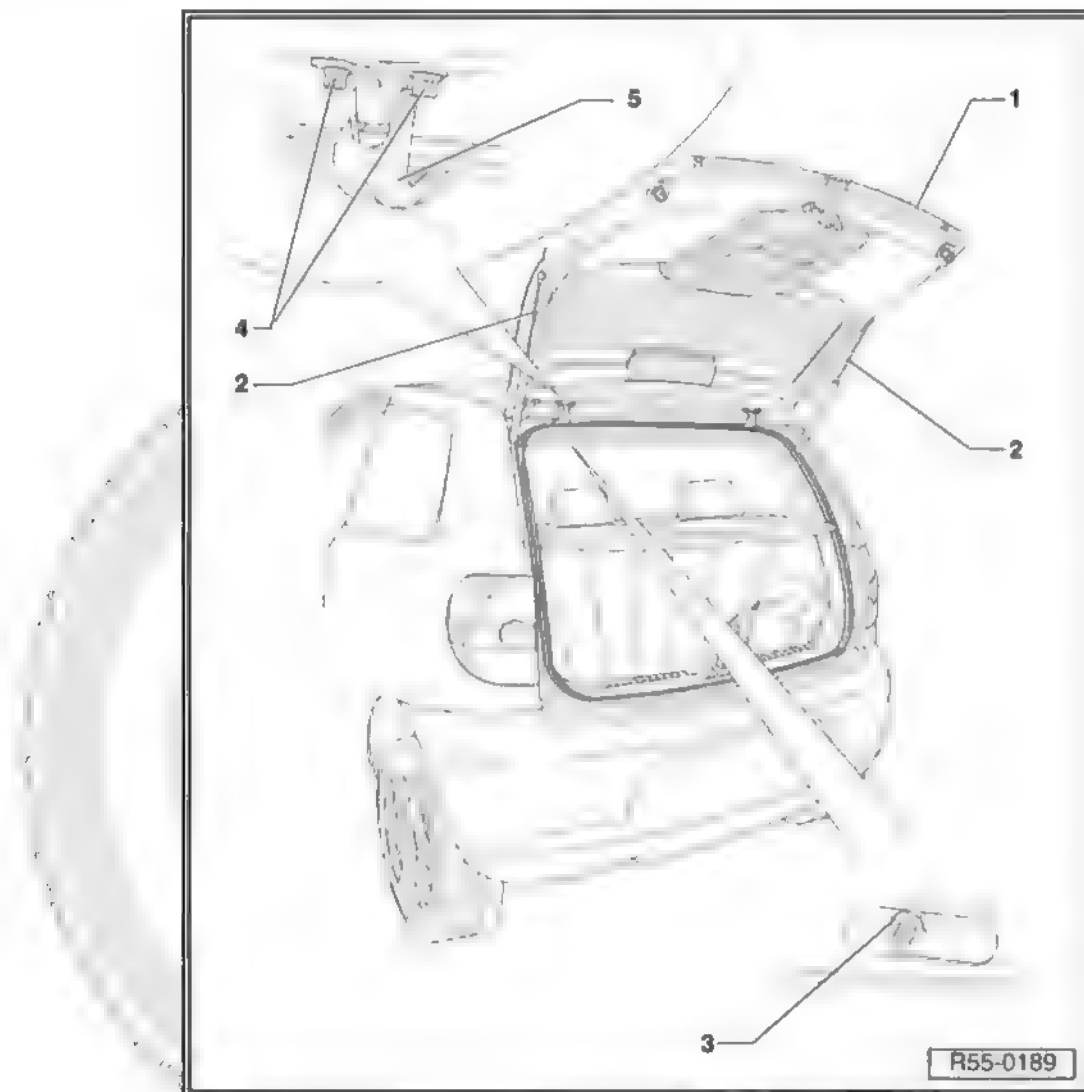
Installation is performed in the reverse sequence of the removal.



- Torque of screws: 10 Nm
- Adjust the cover ➔ [page 27](#) .
- Before closing the rear door, check rear door locking device motor operation.

2.6 Rear lid hinge - remove and install

2.6.1 Remove



- Remove rear door -1-.
- Remove the pillar C lining ➔ Body - Internal assembly works; Rep. gr. 70 ; Lining / insulation .
- Lower the roof lining ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Remove the nut -3- that fastens the hinge to the rear roof cross member.

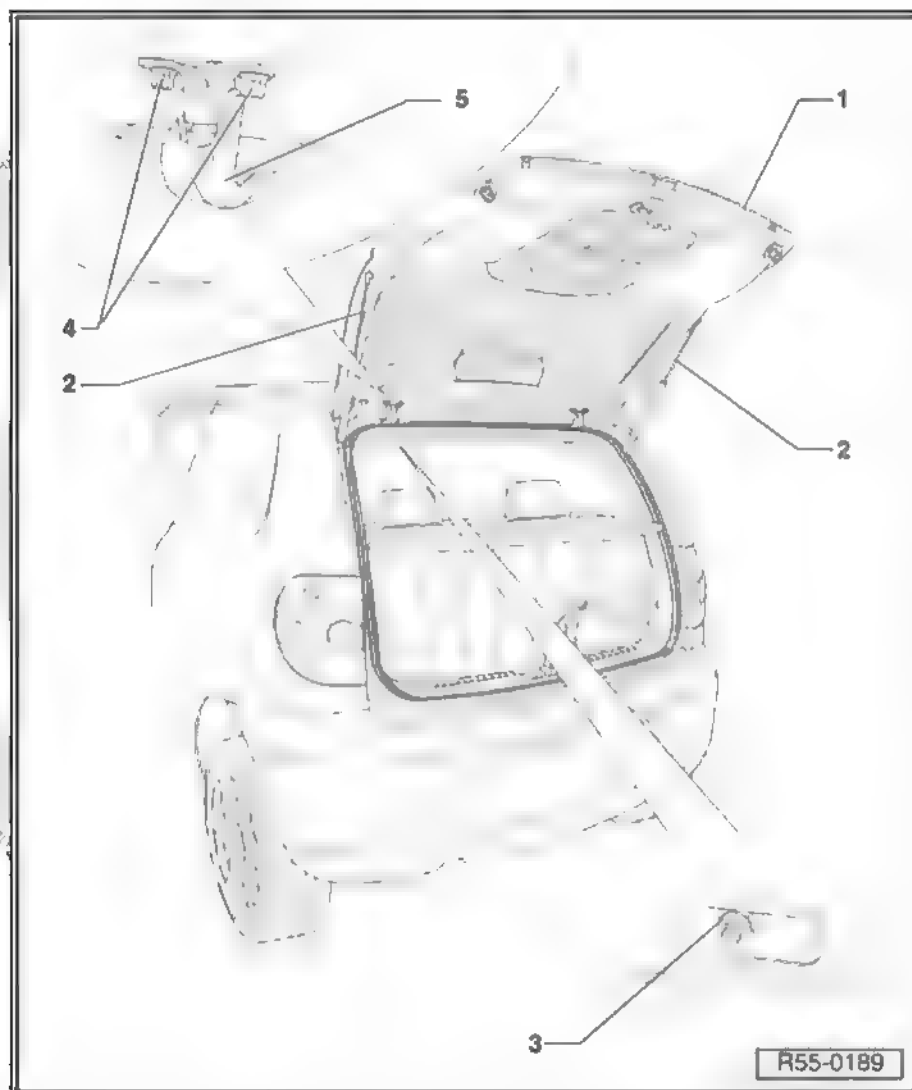


2.6.2 Install



Note

Apply tightening torque on the nut -3- after installing the rear door
-1-.



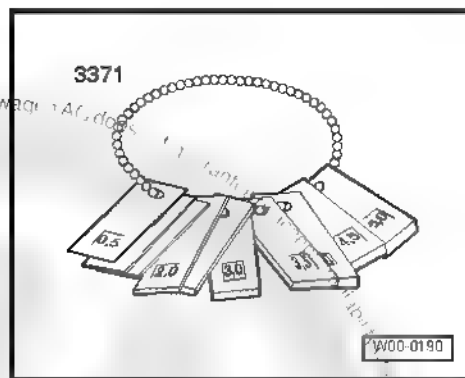
- Install the hinge -5- and tighten the nut -3- to 24 Nm.
- Install the rear lid
- Tighten the nut -3- again to tightening torque of 24 Nm.
- Install the C-pillar lining ⇒ General body repairs, interior; Rep. gr. 70 , Lining / insulation
- Install the roof lining ⇒ General body repairs, interior, Rep. gr. 70 , Lining / insulation

2.7 Rear lid - adjust

Special tools and workshop equipment required



♦ Adjustment gauge - 3371-

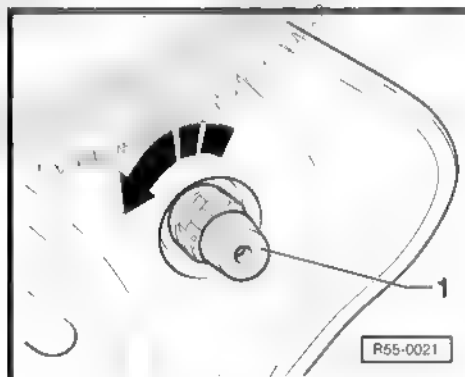


Note

- ♦ The rear lid is properly adjusted when its clearance is the same at all points when it is closed, not being too much inward or outward, and when contours match.
- ♦ Check clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- ♦ The vehicle wheels must be on the floor so that the adjustment can be made.

Stop adjustment

- Turn the adjustment buffer 90° with a ring spanner (SW 24) and remove it.
- Remove rubber buffer -1- from adjustment buffer and loosen fastening screw (3-mm internal hexagonal) until hitch sliding mechanism can be removed.

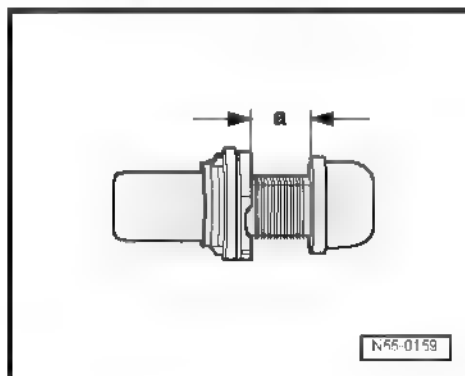


- Pull hitch sliding mechanism out of body and adjust with dimension a = 12.5 mm.



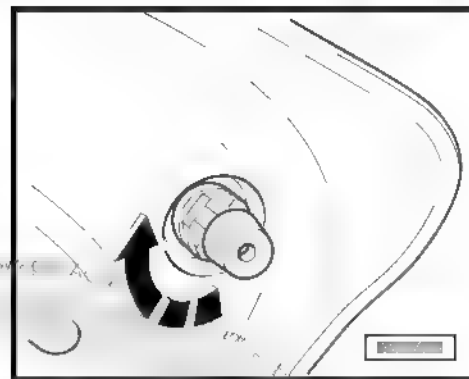
Note

A new adjustment stop is already adjusted on a 12.5-mm distance

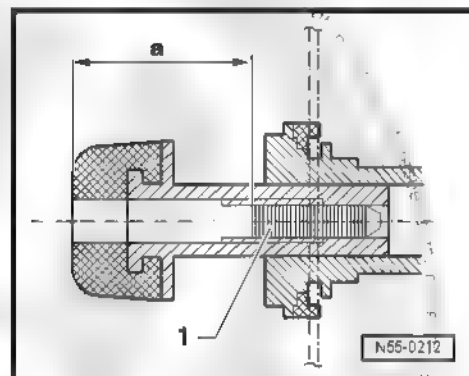




- Place adjustment buffer and assemble in the sectional hole with a 90° turn.
- Close rear door until preliminary lock by slightly pressing its central section.
- Open the rear lid again



- Screw fastening screw -1- to $a = 20.5 \text{ mm}$.
- Check adjustment.



2.8 Rear lid lock (➤ 12.04) - remove and install

2.8.1 Vehicles without central locking



1 - Bolt

- ☐ Torque: 8 Nm

2 - Rear lid

3 - Connector

4 - Lock cylinder housing

- ☐ Remove:
- Remove door latch
⇒ [Item 7 \(page 30\)](#).
- Press latch plastic cover
a little aside and remove
fastening screw
⇒ [Item 6 \(page 30\)](#)
from lock cylinder hous-
ing.
- Remove lock cylinder
housing from door latch.
- ☐ Install:
- Join lock cylinder hous-
ing and door latch (at-
tention to locking).
- Screw fastening screw
⇒ [Item 6 \(page 30\)](#) of
lock cylinder housing.
- Install door latch
⇒ [Item 7 \(page 30\)](#).

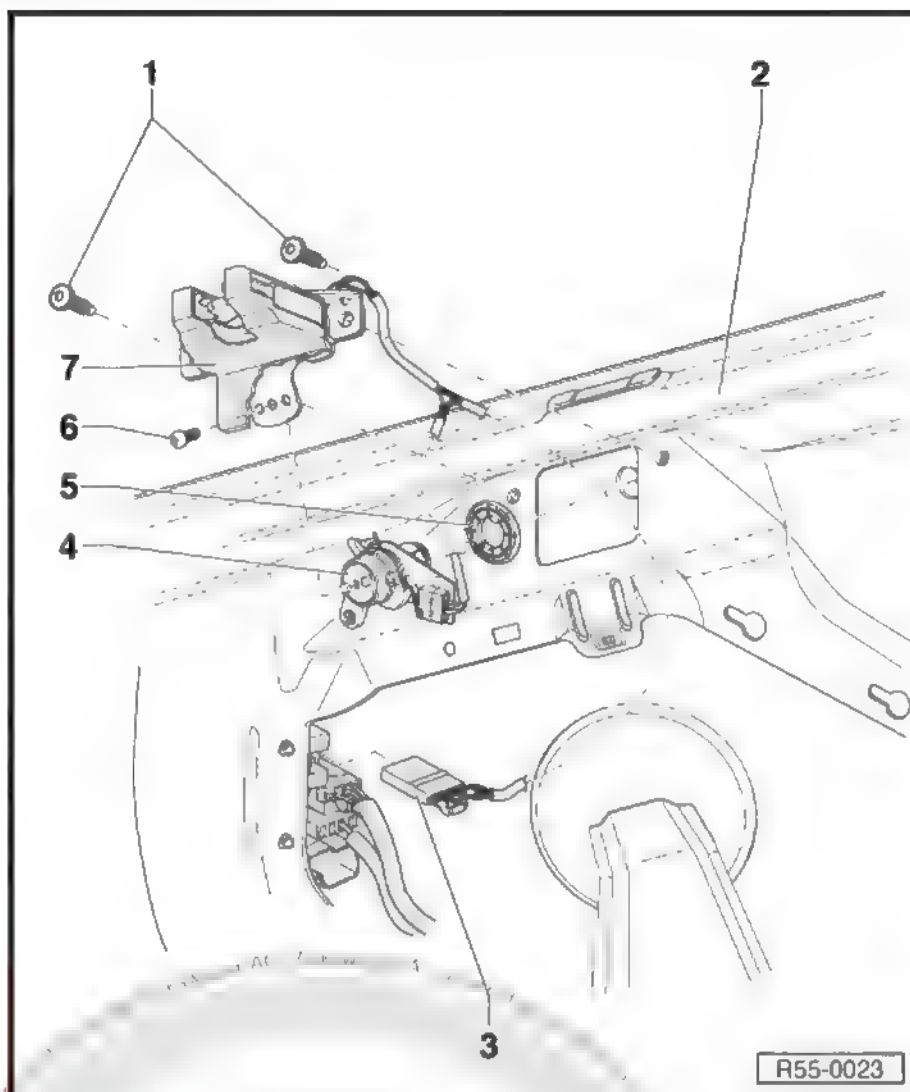
5 - Sealing ring

6 - Bolt

- ☐ Torque: 3 Nm

7 - Latch

- ☐ remove:
- Remove the rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Disconnect connector ⇒ [Item 3 \(page 30\)](#) -3-.
- Remove screws ⇒ [Item 1 \(page 30\)](#) -1- and remove latch with lock cylinder housing
⇒ [Item 4 \(page 30\)](#) out of door.
- ☐ Install - only if rotating part is engaged





2.8.2 Vehicles with central locking

1 - Bolt

- ☐ Torque: 8 Nm

2 - Rear lid

3 - Bolt

- ☐ Torque: 3 Nm

4 - Connector

5 - Rear lid release motor - V139-

- ☐ Remove:
 - Remove the rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Loosen some of the screws' thread steps ⇒ [Item 3 \(page 31\)](#) -3-.
 - Move motor over the rear door plate elongated holes, and remove it.
 - Disengage inversion lever ⇒ [Item 6 \(page 31\)](#) -6-.
- ☐ Install - reverse sequence

6 - Inversion lever

7 - Connector

8 - Bushing

- ☐ replace if necessary

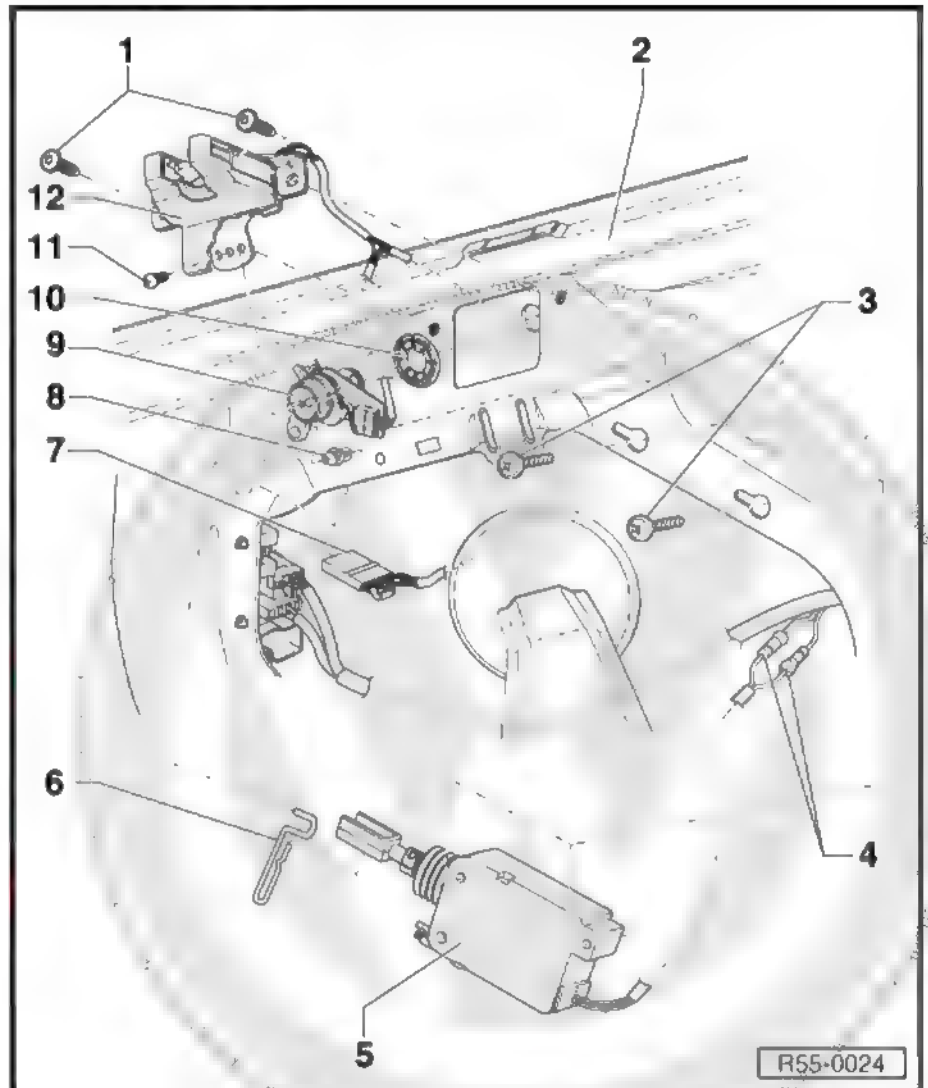
9 - Lock cylinder housing

- ☐ Request
- ☐ Remove:
 - Remove door latch ⇒ [Item 12 \(page 32\)](#) -12-.
 - Press latch plastic cover a little aside and remove fastening screw ⇒ [Item 11 \(page 31\)](#) -11- from lock cylinder housing.
 - Remove lock cylinder housing from door latch.
- ☐ Install:
 - Join lock cylinder housing and door latch (attention to locking).
 - Tighten fastening screw ⇒ [Item 11 \(page 31\)](#) -11- of lock cylinder housing.
 - Install door latch ⇒ [Item 12 \(page 32\)](#) -12-.

10 - Sealing ring

11 - Bolt

- ☐ Torque: 3 Nm





12 - Latch

☐ Remove:

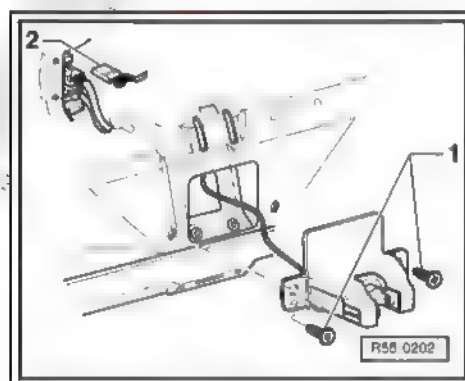
- Remove the rear lid lining → General body repairs, interior; Rep. gr. 70 ; Lining / Insulation - Luggage compartment lining
- Disconnect connector → [Item 7 \(page 31\)](#) -7-.
- Loosen screws → [Item 1 \(page 31\)](#) -1-.
- Disengage inversion lever → [Item 6 \(page 31\)](#) -6- and remove latch with lock cylinder housing → [Item 9 \(page 31\)](#) -9- out of door.

☐ Install - only if rotating part is engaged

2.9 Rear lid lock (01.05 ►) - remove and install

2.9.1 Remove

- Remove the rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / Insulation - Luggage compartment lining
- Disconnect the connector -2- of the luggage compartment switch - F5- .
- Remove the bolts -1-.
- Remove the latch along with the luggage compartment lighting switch - F5- harness



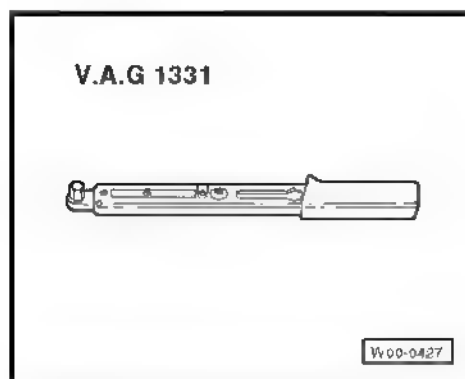
2.9.2 Install

- Installation is performed in the reverse sequence of the removal.

2.10 Rear lid lock cylinder handle (Push Button - 01.05 ►) - remove and install

Special tools and workshop equipment required

- ♦ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





- 1 - Handle lock
- 2 - Switch support
- 3 - Coupling
- 4 - Bolt
- 5 - Reinforcement
- 6 - Wrench
- 7 - Cylinder
- 8 - Handle

☐ Remove

- Remove the rear lid lining ⇒ General body repairs, interior; Rep. on 70 ; Lining / insulation .

- Disengage operating rod -3- from cylinder switch.

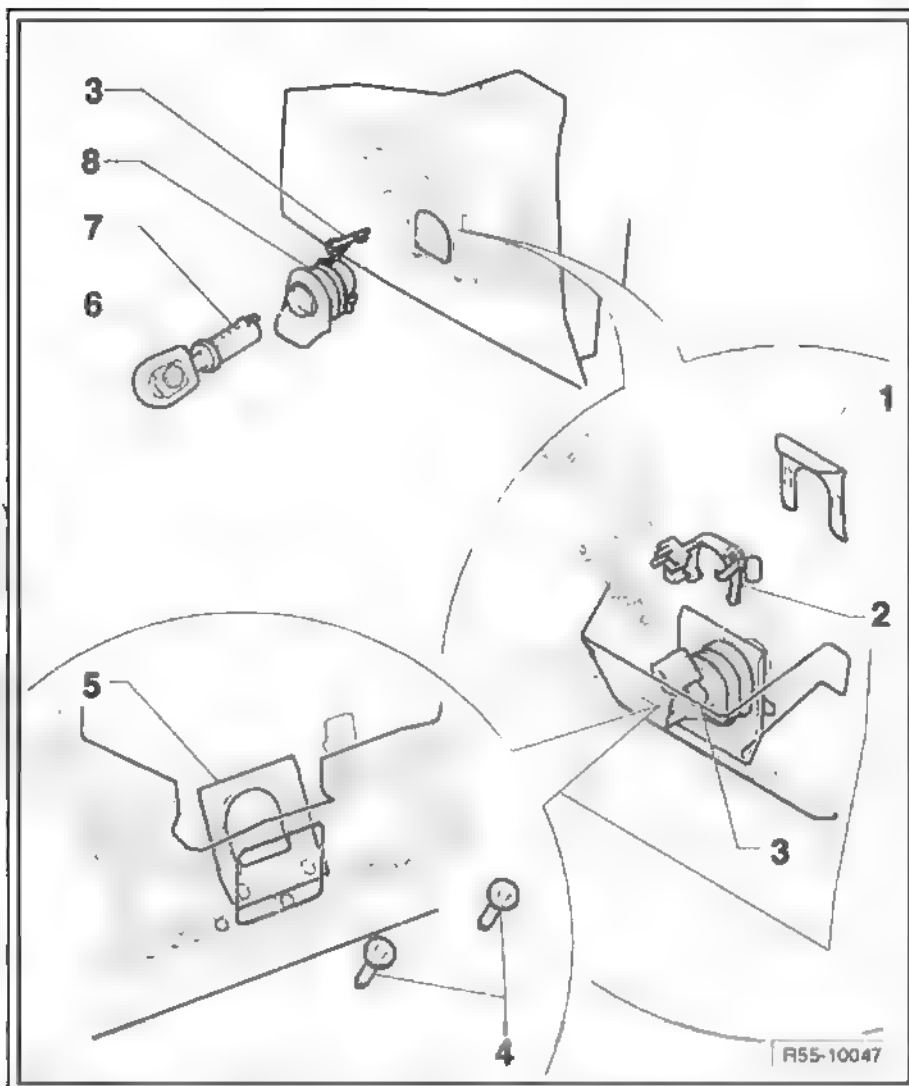
Remove handle lock -1-.

- Disengage and remove the handle.

☐ Install

- Installation is performed in the reverse sequence of the removal.

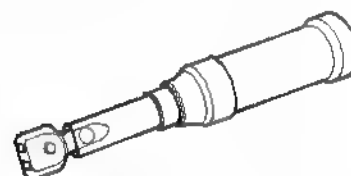
9 - Device motor operating rod fastening



2.11 Rear lid release motor - V139- (Push Button - 01.05 ►) - remove and install

Torque wrench 2 to 10 Nm - VAG 1783-

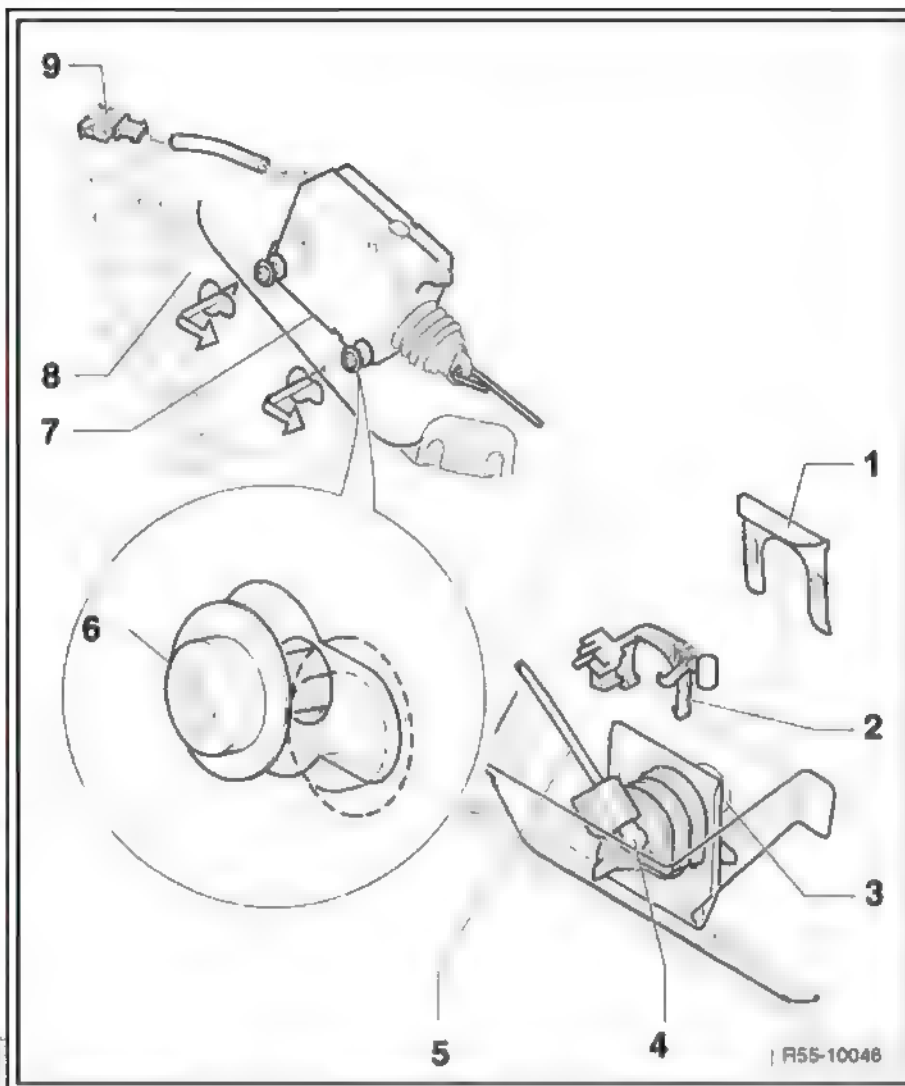
V.A.G 1783



W00-0990



- 1 - Handle lock
- 2 - Mounting bracket
- 3 - Door handle
 - ❑ Remove and install
→ [page 32](#)
- 4 - Coupling
- 5 - Operating rod
- 6 - Bolt
 - ❑ Torque: 2.5 Nm
- 7 - Rear lid release motor - V139-
 - ❑ Remove
 - Remove the rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
 - Loosen screws
⇒ [Item 6 \(page 34\)](#) -6-.
 - Move motor over the rear door plate elongated holes, and remove it.
 - ❑ Disengage coupling rod
⇒ [Item 3 \(page 34\)](#) -3-.
 - ❑ Install
 - Installation is performed in the reverse sequence of the removal.
- 8 - Rear lid interior panel
- 9 - Harness connector



2.12 Lock cylinder (Push Button - 01.05 ►) - assembly overview

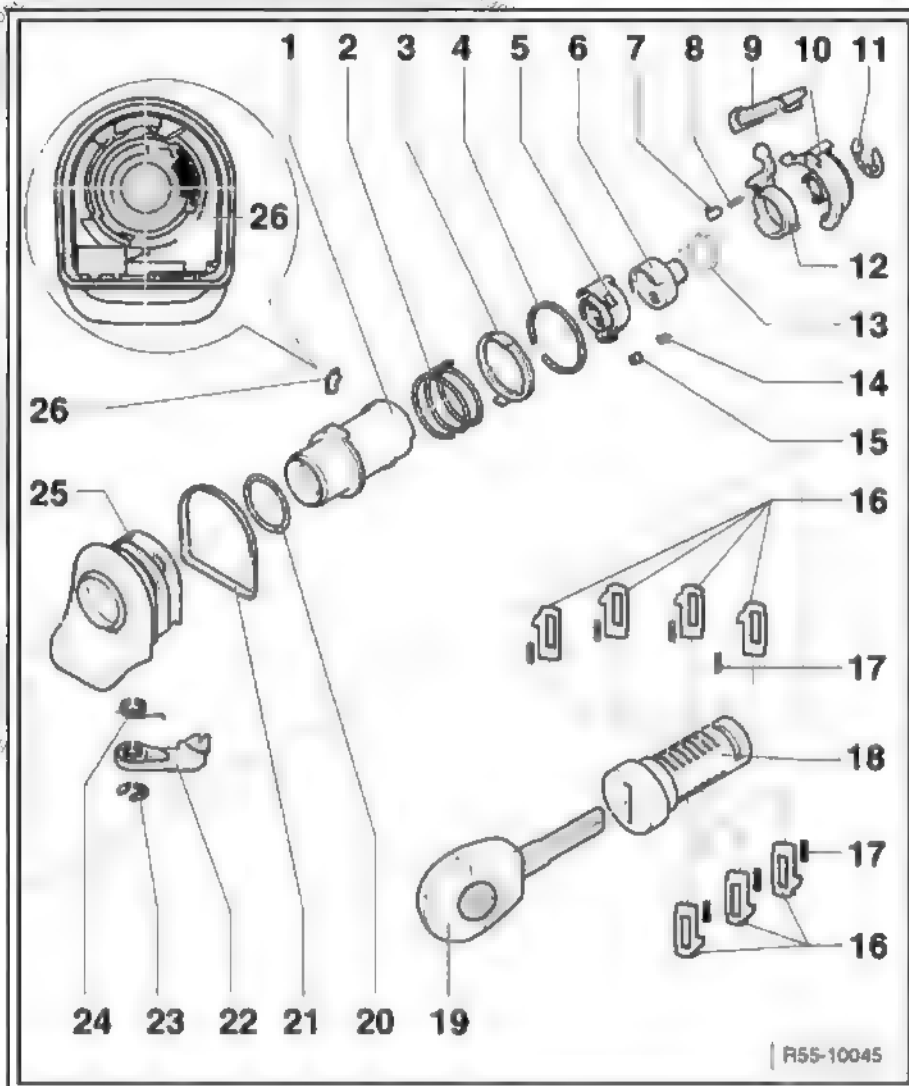


WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



- 1 - Cylinder guide
- 2 - Spring
- 3 - Limiter
- 4 - Retaining ring
- 5 - Actuator
 - ☐ without locking system
 - ☐ fastened by lock -26-
- 6 - Actuator
 - ☐ for motor for unlocking rear door. - V139-
 - ☐ fastened by lock -26-
- 7 - Roller
 - ☐ for motor for unlocking rear door. - V139-
- 8 - Spring
 - ☐ for motor for unlocking rear door. - V139-
- 9 - Coupling
 - ☐ for motor for unlocking rear door. - V139-
- 10 - Actuator
 - ☐ for motor for unlocking rear door. - V139-
- 11 - Snap ring
 - ☐ for motor for unlocking rear door. - V139-
- 12 - Actuator
 - ☐ for motor for unlocking rear door. - V139-
- 13 - Return spring
 - ☐ for motor for unlocking rear door. - V139-
- 14 - Spring
- 15 - Roller
- 16 - Gorges
 - ☐ Lubricate with special grease - G 000 450 02-
- 17 - Spring
- 18 - Cylinder
 - ☐ Lubricate with special grease - G 000 450 02-
 - ☐ Remove and install → [page 36](#)



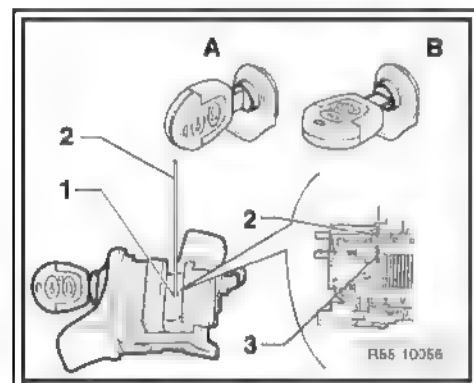


- 19 - Wrench
- 20 - Ring
- 21 - Additional seal
- 22 - Lever
- 23 - Snap ring
- 24 - Spring
- 25 - Handle
- 26 - Retaining clip

2.13 Lock cylinder (Push Button - 01.05 ►) - remove and install

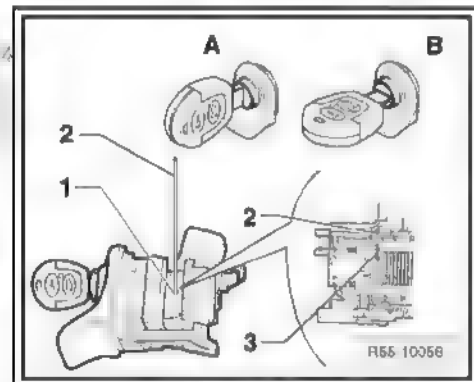
2.13.1 Remove

- Remove handle ⇒ [page 32](#) .
- Insert the key in the cylinder.
- Place key in position -B-.
- Press cylinder and insert a shim in order to access hole -1-.
- With a steel pin -2-, press cylinder lock -3-.
- Remove the cylinder along with key, slowly and carefully turning cylinder left and right.



2.13.2 Install

- Insert cylinder with key in position -A-.
- Press cylinder against the handle until locking -3-.





3 Rear lid (Spacefox)

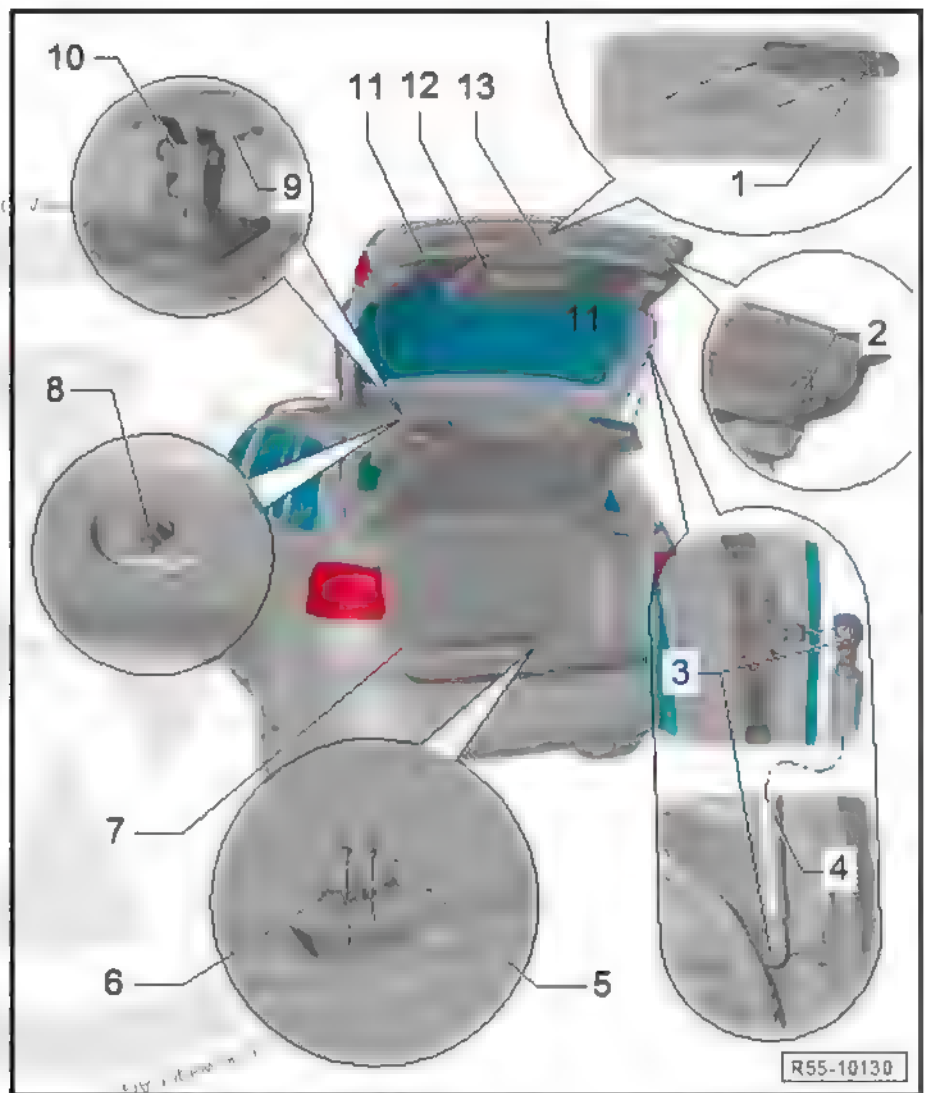
3.1 Rear lid - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

- 1 - Draining membrane
- 2 - Adjustment buffer
 - ☐ Adjust
- 3 - Lid damper lock
- 4 - Rear lid shock absorber
 - ☐ Remove and install ⇒ [page 38](#)
 - ☐ Replace ⇒ [page 23](#)
 - ☐ Lubricate eyelets with lubricating grease - G 052 745 A3-
- 5 - Bolt
 - ☐ 2 units
 - ☐ Torque 8 Nm
- 6 - Rear lid buffer
 - ☐ Remove rear panel lining for access ⇒ *General body repairs, interior; Rep. gr. 70 ; Lining / insulation*
 - ☐ Adjust: through elongated holes
 - ☐ Clearance dimensions ⇒ *Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions*
- 7 - Rear lid trim
 - ☐ Remove and install ⇒ [page 39](#)
- 8 - Fastening nut
 - ☐ 1 unit
 - ☐ Torque 24 Nm
- 9 - Bolt
 - ☐ 2 units
 - ☐ Torque 10 Nm
- 10 - Lid hinge
 - ☐ Remove and install ⇒ [page 41](#)





11 - Rear lid

- ☐ Remove and install ➔ [page 40](#)
- ☐ Adjust ➔ [page 42](#)

12 - Hatch lining

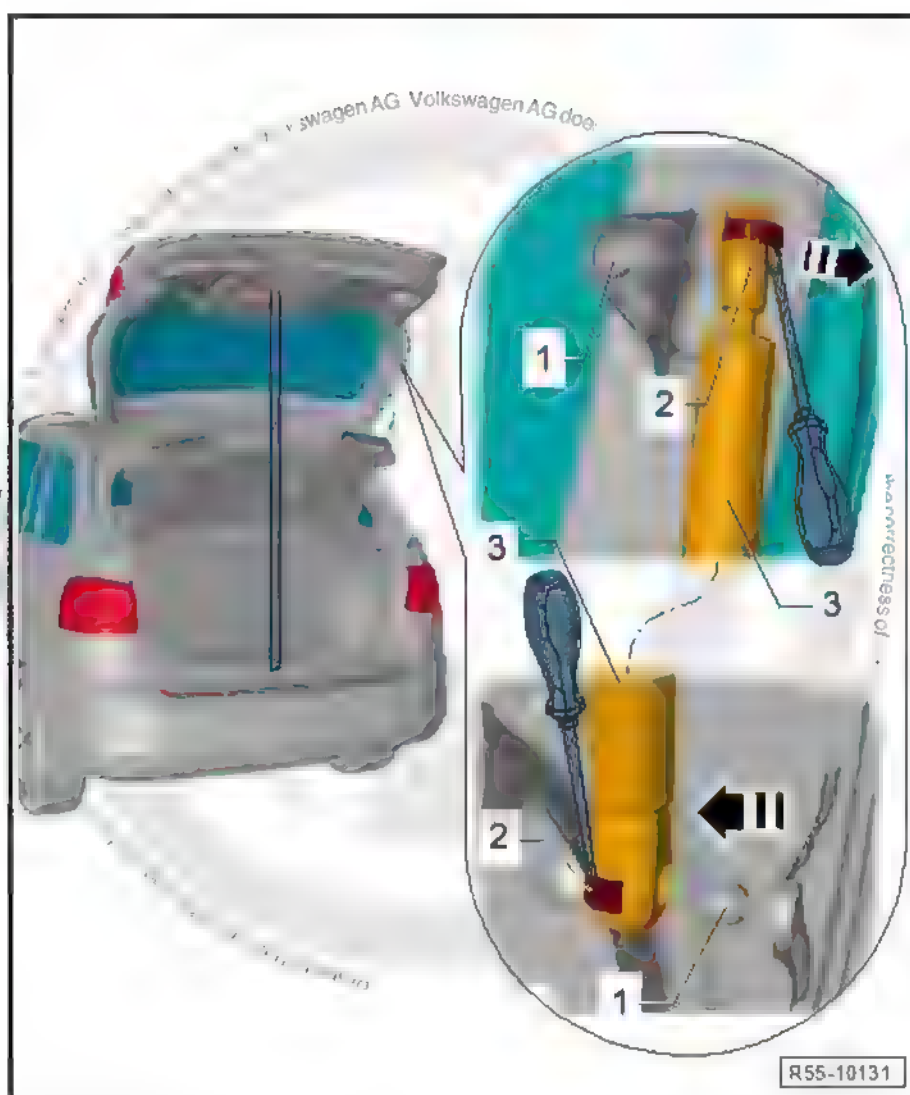
- ☐ remove and install ➔ General body repairs, interior, Rep. gr. 70 , Lining / Insulation - Rear lid lining - remove and install

13 - Rear door latch

- ☐ Remove and install ➔ [page 42](#)

3.2 Rear door shock absorber - remove and install

- Support the rear lid.



- Place a small screwdriver underneath the spring clip -2-.
- Raise the clip -2-enough to allow the clip to move over the ball joint housing in the -direction of arrow-.
- Pull the gas shock absorber -3- from the joint pins -1-.



- After removing the shock absorber -1-, move the clip -2- back immediately.

i Note

Be careful when installing the shock absorber. The clip -2- cannot be completely disengaged from the ball joint housing; otherwise, it will be damaged. If the shock absorber fastening is damaged, there is the risk of accident or personal injury.

3.3 Rear door shock absorber - replace

See Rear lid damper - replace ➔ [page 23](#)

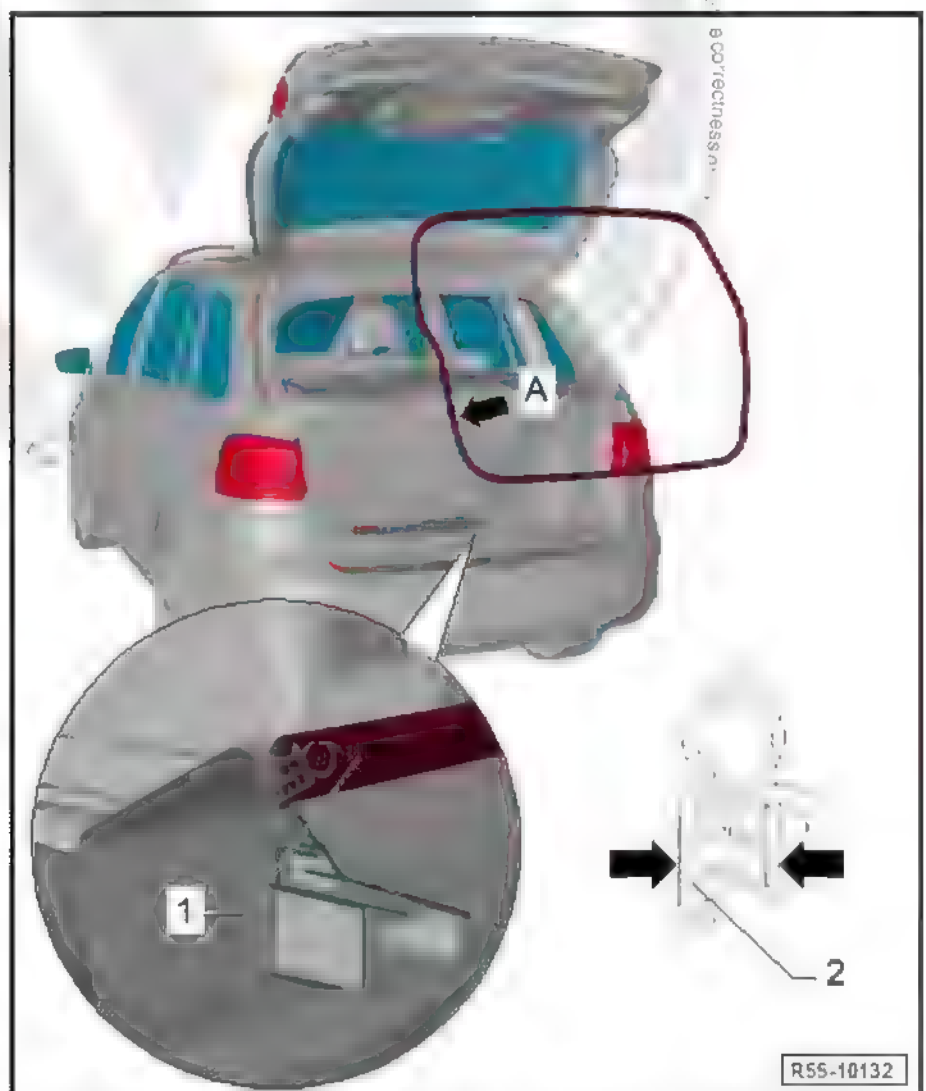
3.4 Rear lid trim - remove and install

1 - Additional seal

- ☐ start with the flange next to the left rear light to install the trim -arrow A-.
- ☐ New part installation shall be carried out by slightly tapping with a rubber hammer

2 - Trim metal frame

- ☐ For partially removed trim, it is necessary to press the trim's sides -arrows- before assembly.





3.5 Rear lid - remove and install

3.5.1 Remove



- Open rear door -1-.
- Remove the rear lid lining ⇒ General body repairs, interior;
Rep. gr. 70 ; Lining / insulation .
- Disengage electric connections and the rear window washer
hose.
- Remove electric harnesses from door.
- Release the bolts -3- from hinge -4-.

For the items below, you will need the help of an assistant.

- Remove the rear door shock absorber rod -2- from the rear
door -1-.
- Remove the bolts -3- and remove the lid.

3.5.2 Install

Installation is performed in the reverse sequence of the removal.



- Torque of screws: 10 Nm
- Adjust the rear door.
- Before closing the rear door, check rear door locking device motor operation.

3.6 Rear lid hinge - remove and install

3.6.1 Remove

- Remove the rear lid ➔ [page 40](#) .
- Remove the C-pillar covering ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; C-pillar lining - remove and install .
- Remove the D-pillar covering ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; D-pillar lining - remove and install .
- Lower the headliner.



- Remove the nut -1- that fastens the hinge to the rear roof cross member.



3.6.2 Install



Note

Apply torque to the union nut in the hinge after installing the rear lid.

- Install the lid and tighten the nut temporarily.
- Install the rear lid.
- Tighten the hinge union nut to a torque of 24 Nm
- Install the C-pillar covering ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; C-pillar lining - remove and install .
- Install the D-pillar covering ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; D-pillar lining - remove and install .

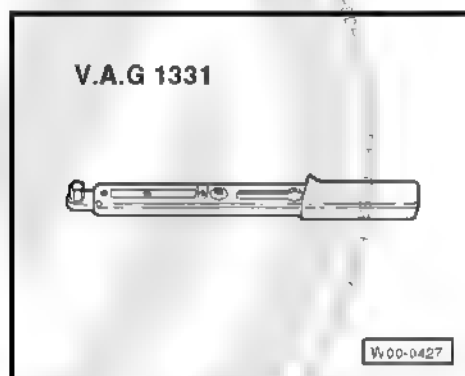
3.7 Rear lid - adjust

Refer to: Rear lid - adjust ⇒ [page 27](#)

3.8 Rear lid lock - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





1 - Bolt

- ☐ Torque: 8 Nm

2 - Latch

- ☐ Remove

- Remove the rear lid lining → General body repairs, interior; Rep gr 70 ; Lining / insulation .

- Remove the bolts -1-.

- Disconnect the connector -12- of the luggage compartment switch - F5- .

- Remove the lock -2-.

- ☐ Install

- Installation is performed in the reverse sequence of the removal.

3 - Switch support

4 - Sealing ring

5 - Handle

- ☐ Remove and install
⇒ [page 43](#)

6 - Connector

7 - Rear lid release motor - V139-

- ☐ Remove and install
⇒ [page 43](#)

8 - Operating rod

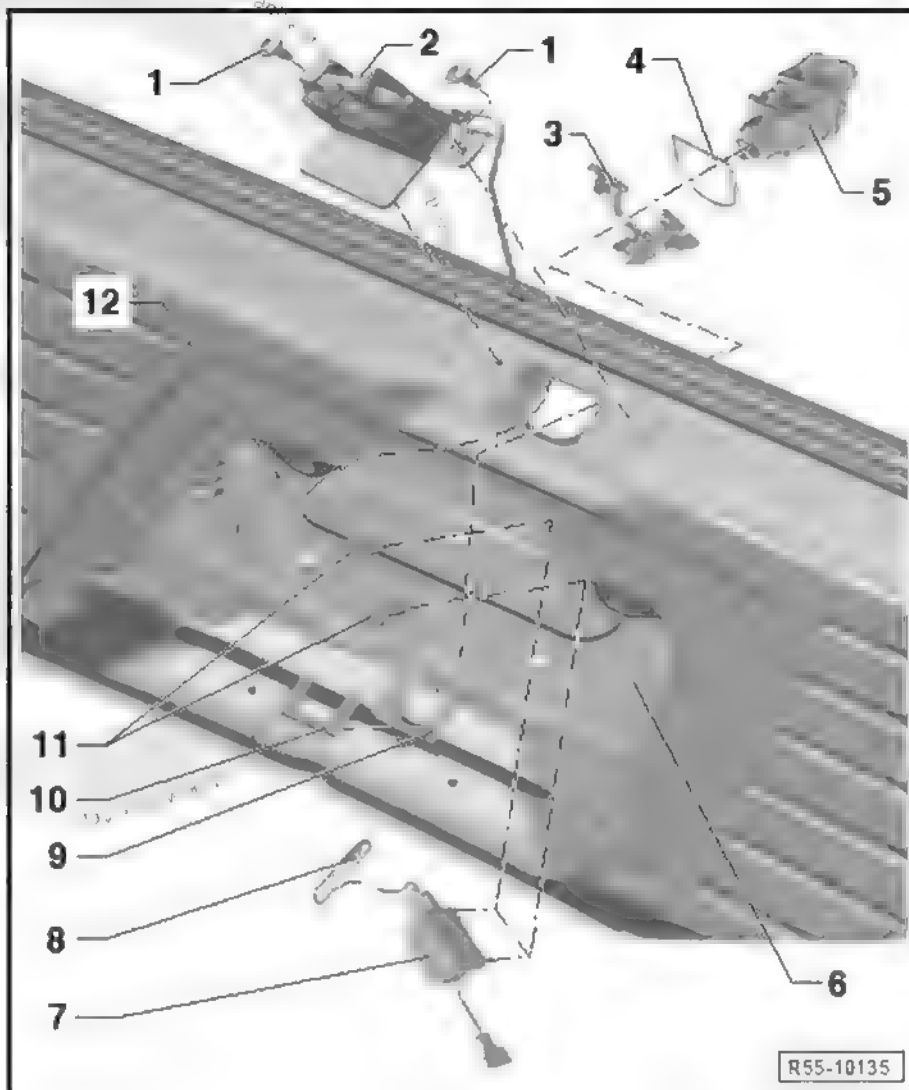
9 - Handle reinforcement

10 - Handle lock

11 - Bolt

- ☐ Torque: 3 Nm

12 - Connector



3.9 Rear lid lock cylinder handle - remove and install

Refer to "Rear lid lock cylinder handle (Push Button - 01.05 ▶) - remove and install" ⇒ [page 32](#)

3.10 Rear lid release motor - V139- - remove and install

Refer to "Rear lid release motor V139 (Push Button - 01.05 ▶) - remove and install" ⇒ [page 33](#)

3.11 Lock cylinder - assembly overview

Refer to "Lock cylinder (Push Button - 01.05 ▶) - assembly overview" ⇒ [page 34](#)



3.12 Latch cylinder - remove and install

Refer to "Lock cylinder (Push Button - 01.05 ►) - remove and install" → [page 36](#)





4 Fuel reservoir nozzle compartment and lid set

4.1 Fuel tank nozzle compartment and lid set - remove and install

1 - Side panel

2 - Expansion nut

3 - Fuel reservoir nozzle compartment and lid set

- ☐ Constituted by fuel reservoir lid -4- and reservoir nozzle compartment -6-

- ☐ Remove:

- Remove the fuel tank cap.
- Loosen the bolt -5-
- Remove rubber part from fuel reservoir nozzle and turn the lid set outwards the side panel.

- ☐ Install:

- First assemble the fuel nozzle compartment and lid set (fitted rubber part) with the hinge side.
- Tighten the bolt -5-.

4 - Fuel tank cap

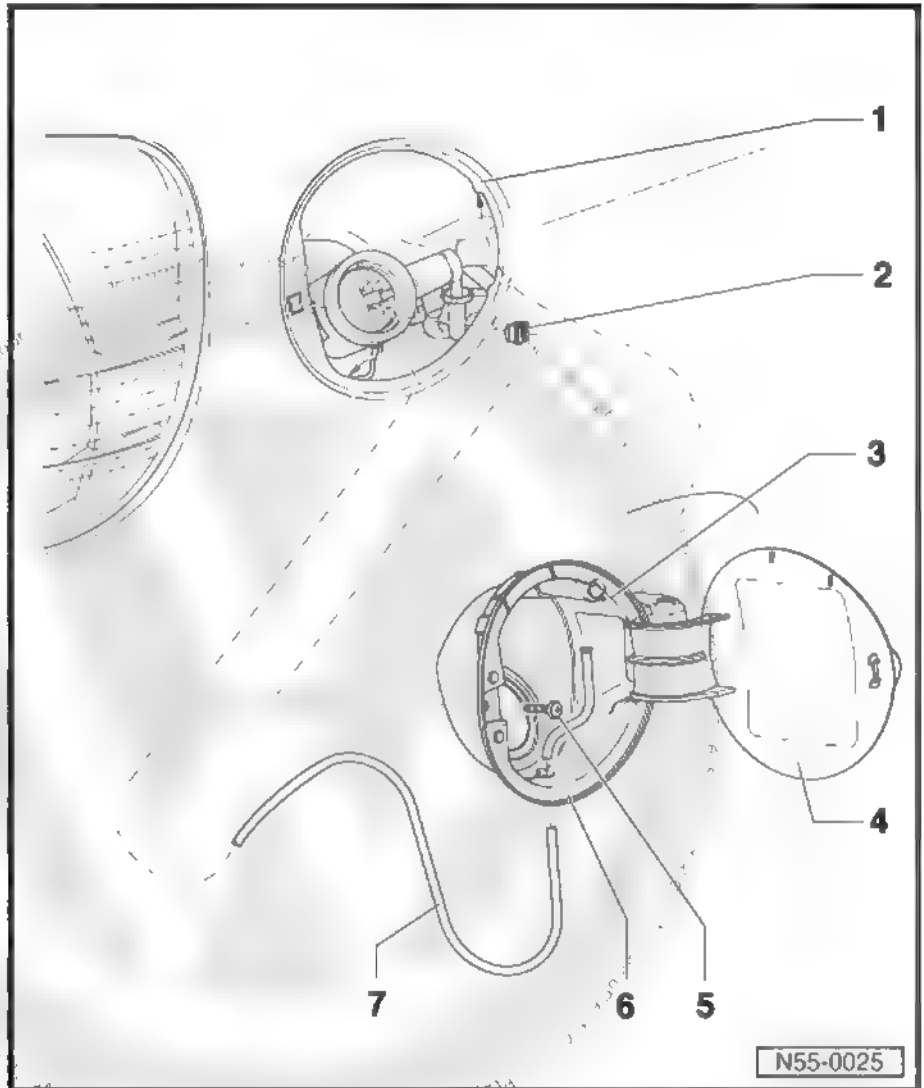
- ☐ can only be removed as refueling nozzle lid unit -3-.
- ☐ to remove fuel reservoir lid, press fastening pin of the refueling nozzle door unit.

5 - Bolt

6 - Fuel nozzle lid compartment

- ☐ can only be removed with the fuel reservoir nozzle compartment and lid set -3-.
- ☐ to remove fuel reservoir lid, press fastening pin of fuel nozzle lid

7 - Draining hose





57 – Front doors, door components, central locking

1 Front door

1.1 Front door - assembly overview



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



Note

- ◆ *The door hinge screws must always be replaced after being released.*
- ◆ *The dash panel must be removed to remove and adjust the upper door hinges.*



1 - Multi-tooth screw

- ☐ M 8
- ☐ assembled from inside the vehicle
- ☐ to loosen or fasten threshold screw ⇒ General body repairs, interior; Rep gr. 68; Internal equipment
- ☐ Torque: 20 Nm + 1/4 turn (90°)
- ☐ Screws must always be replaced when removed

2 - Multi-tooth screw

- ☐ M 8
- ☐ Torque: 20 Nm + 1/4 turn (90°)
- ☐ Screws must always be replaced when removed

3 - Door hinge

- ☐ In two sections

4 - Hinge pin

5 - Nut

- ☐ Torque: 14 Nm

6 - Multi-tooth screw

- ☐ M 8
- ☐ Torque: 20 Nm + 1/4 turn (90°)
- ☐ Screws must always be replaced when removed

7 - Support

8 - Lock cylinder housing, or housing without lock cylinder

- ☐ Remove and install ⇒ [page 55](#)

9 - Cover cap

- ☐ Paint according to ⇒ Paint Manual - Repairing paintwork in plastic parts .

10 - Door handle

- ☐ Paint according to ⇒ Paint Manual - Repairing paintwork in plastic parts .
- ☐ Remove and install ⇒ [page 59](#)

11 - Support

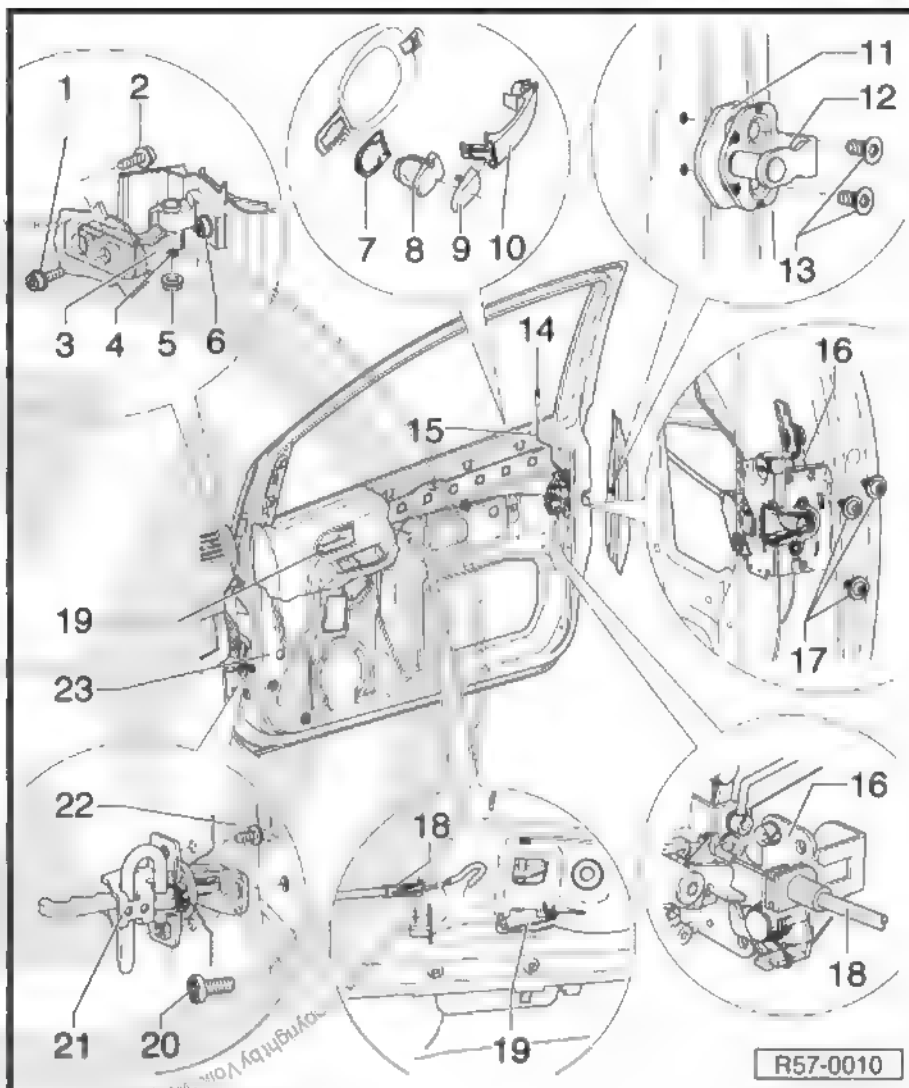
12 - Latch plate

13 - Bolt

- ☐ Torque: 20 Nm
- ☐ PowerLock

14 - Locking button

- ☐ Fastened to the locking rod
- ☐ For Europe versions, button on -locked door- position shall be "0 to 2 mm" above button frame.
- ☐ For other versions except Europe, upper end of button must be 19 mm above door lining, on -locked door- position. On -unlocked door-position, the upper end of button shall be 29 mm above the door lining.





15 - Locking rod

16 - Door lock

- ☐ Remove and install ➔ [page 60](#)
- ☐ Lubricate with low-temperature grease -G 052 745 A3-

17 - Screw (M6 x 10)

- ☐ Torque: 4 Nm

18 - Lock Bowden cable

19 - Internal door activation

20 - Bolt

- ☐ Torque: 25 Nm

21 - Door limiter

- ☐ Remove and install ➔ [page 52](#)

22 - Bolt

- ☐ Torque: 10 Nm

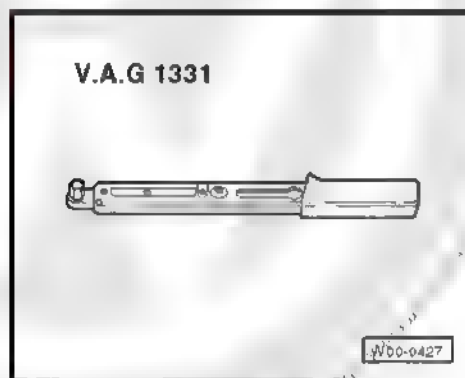
23 - Door

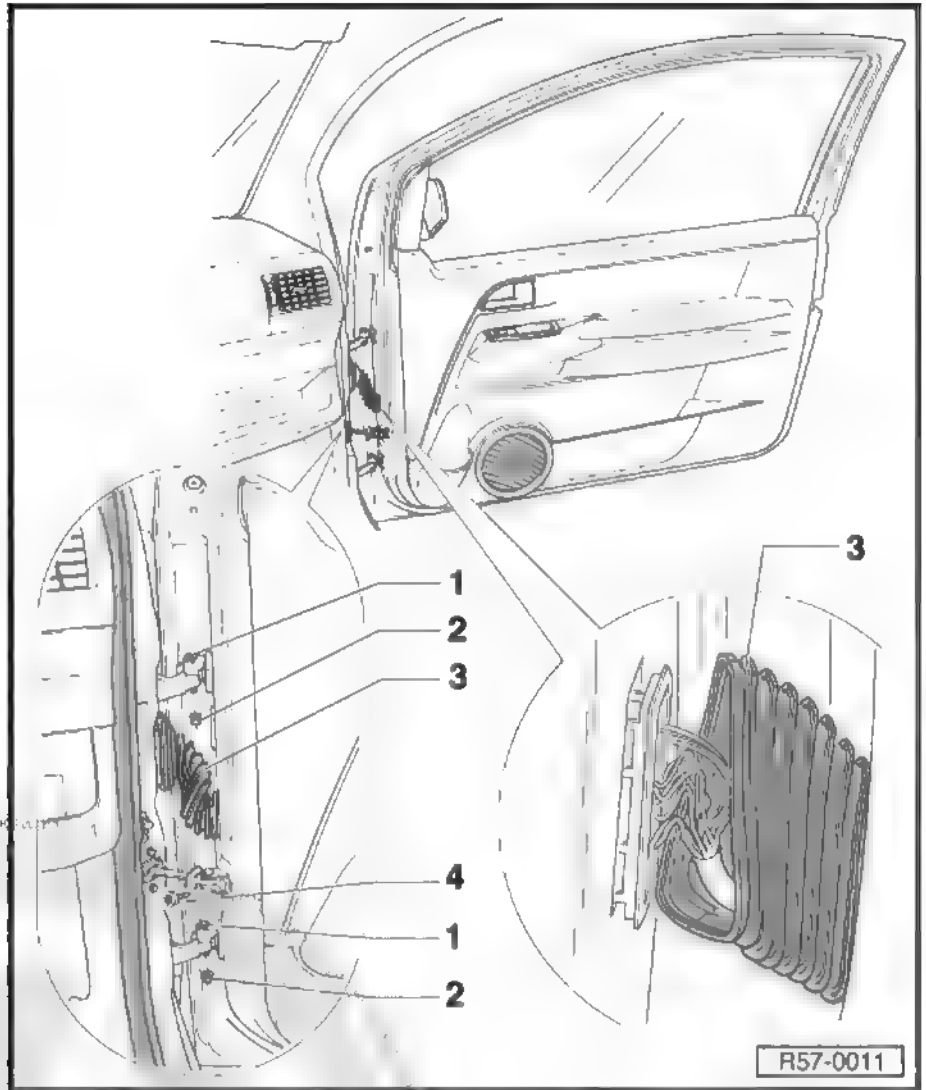
- ☐ Remove and install ➔ [page 48](#)

1.2 Front door - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





Remove

- Pull protection bellows -3- from A-pillar and disconnect electric connections of coupling station located on A-pillar.
- Remove nuts -2- from hinge pins -1-.
- Remove the screw -4- from the door limiter.
- Disengage door upward and out of hinge angle bars.

Install

Install is performed in the reverse sequence, observing the following:

- Tighten the nuts -2- of the hinge pins to 14 Nm.
- Tighten the screw -4- of the door limiter to 25 Nm.

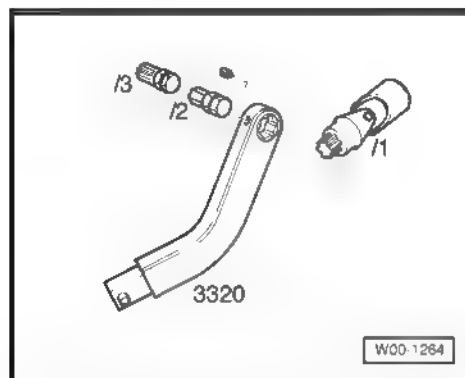
1.3 Front door - adjust

Special tools and workshop equipment required

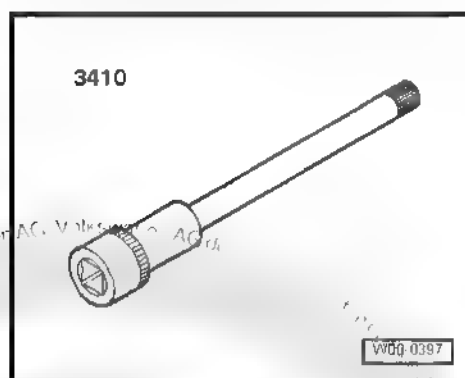
- ◆ Wrench - 3320-



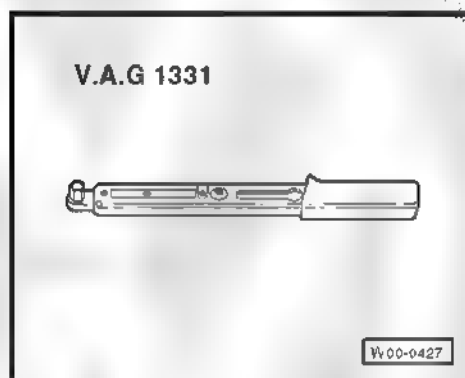
◆ Multi-tooth bits - 3320/3-



◆ Multi-teeth socket - 3410-



◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



Note

- ◆ *Vehicle must be supported by its wheels in order to correctly adjust the front door.*
- ◆ *The front door is correctly adjust when clearances are as specified ⇒ Body Repairs, Rep. gr. 00 ; Technical data, Body clearance dimensions when door is locked.*
- ◆ *Take anticorrosion protection measures on hinges and screws after reinstalling or adjusting*

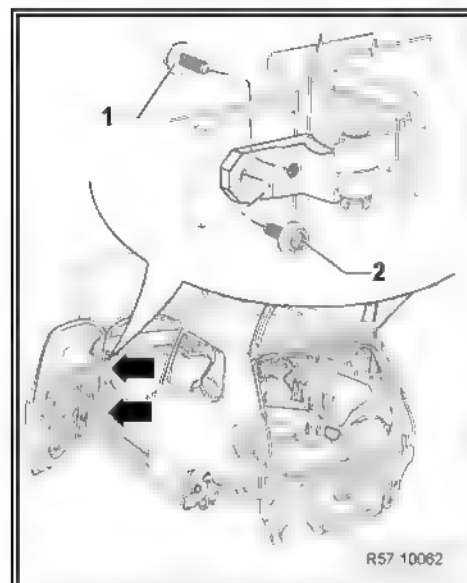


Screws -1- and -2- must be loosen on A-pillar in order to correctly adjust clearances.

- For screw -1- on lower door hinge, lower longitudinal member trim must be removed: ⇒ General body repairs, interior, Rep. gr. 68 , Internal equipment . Loosen screw with multi-tooth socket - 3410- .
- For screw -1- on upper door hinge, the dashboard must be removed: ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations Loosen screw with multi-tooth socket - 3410- .

For screw -2- , loosen it with wrench - 3320- and multi-tooth bits - 3320/3- .

- Adjust the door arrester ⇒ [page 52](#) .



1.4 Front door - disassemble and assemble

1.4.1 Disassemble

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the door sealing membrane ⇒ [page 66](#) .
- Remove the door window drive mechanism:
 - manual drive ⇒ [page 169](#) .
 - electrical drive ⇒ [page 175](#)
- Remove the door window glass ⇒ [page 165](#) .
- Remove the external rear-view mirror ⇒ [page 243](#) .
- Remove the internal and external door window glass trims ⇒ [page 172](#) .
- Remove the door window channel ⇒ [page 172](#) .
- Remove the glass guide rail.
- Remove the external handle ⇒ [page 53](#) .
- Remove the lock ⇒ [page 60](#) .
- Remove the door limiter ⇒ [page 52](#)
- Disconnect the protection bellows and remove the harness from inside the door.

1.4.2 Assembling

- Assembly is preformed in the reverse sequence to disassembly.

1.5 Front door - replace

1.5.1 Remove

- Disassemble the door ⇒ [page 51](#) .
- Remove the door ⇒ [page 48](#) .



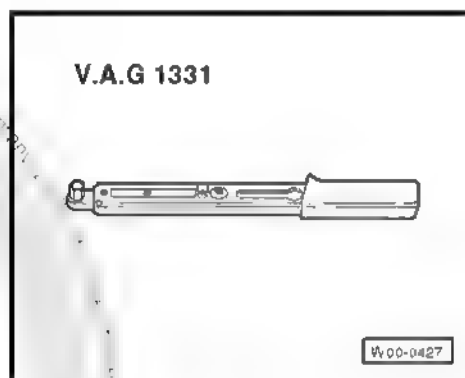
1.5.2 Install

- Apply sealant/caulking to the door → Paint Manual - Body Sealant .
- Install the door noise insulation ⇒ General body repairs, interior; Rep gr. 70 ; Lining / insulation .
- Paint the door ⇒ Painting Manual - Repairing paintwork on steel plates and galvanized steel plates.
- Install the door ⇒ [page 48](#) .
- Apply anti-corrosive fluid ⇒ Paint Manual - Application of anti-corrosive fluid - Anti-corrosive fluid .
- Assemble the door ⇒ [page 51](#) .

1.6 Door arrester - adjust

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



1.6.1 Adjust

- Loosen buffer fastening screws.
- Position buffer and tighten screws temporarily.
- Close the door and check the perfect alignment with the body, check the clearance dimensions specified ⇒ Body Repairs; Rep gr. 00 ; Technical data - Body clearance dimensions .
- Definitely tighten buffer to:
 - 20 Nm (T45)

1.7 Door limiter - remove and install

Special tools and workshop equipment required

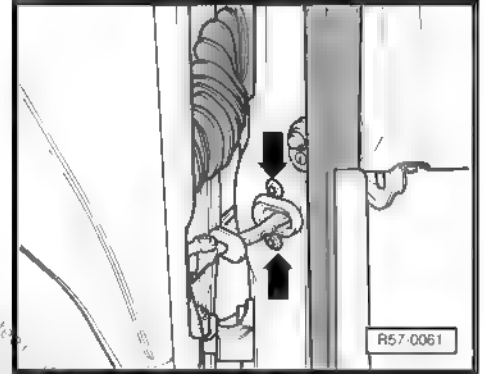
- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





1.7.1 Remove

- Remove front door threshold trim ➔ General body repairs, interior; Rep. gr. 68 ; Linings / insulations .
- Remove the door limiter fastening screw (T-40)
- Remove fastening screws -arrows- from limiter on pillar A (T-30)
- Remove limiter



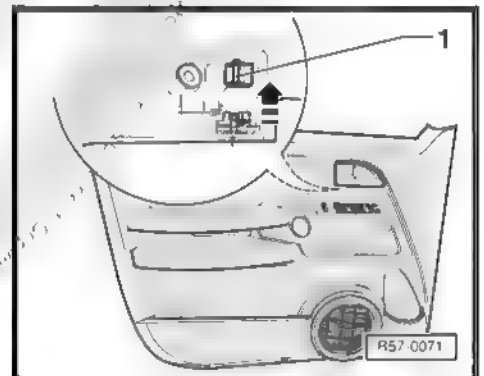
1.7.2 Install

- Installation is performed in the reverse sequence to the removal.

1.8 Internal handle - replace

1.8.1 Remove

- Remove the door lining ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Disengage operating cable from internal handle.
- Move handle joint pin -1- towards the arrow until hitting buffer on the door lining.
- Activate internal handle, loosen spring and disengage it from the door lining.



1.8.2 Install

- Installation is performed in the reverse sequence to the removal.

1.9 Front door external handle and lock - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"



1 - Cap

2 - Door lock

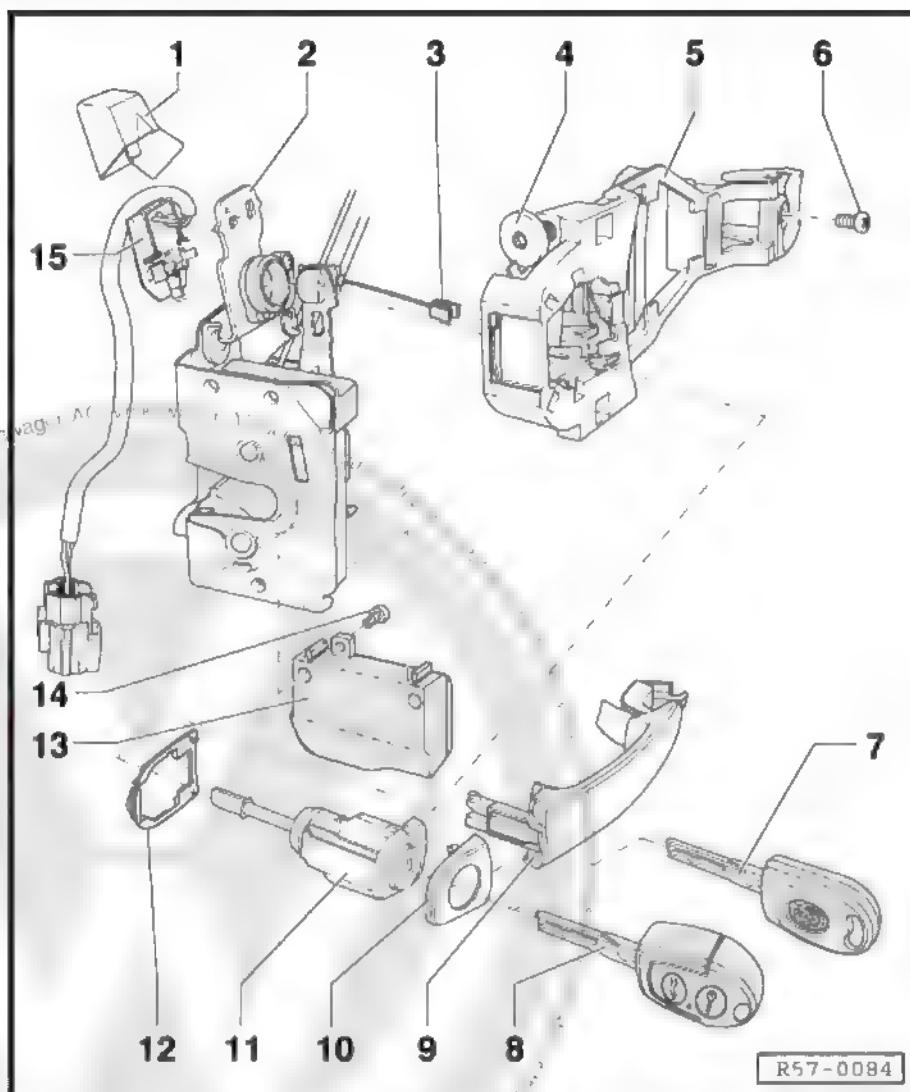
- ☐ Remove and install
➔ [page 60](#)
- ☐ Lubricate with low-temperature grease -G 052 745 A3-

3 - Operating cable

- ☐ Lock unlocking.

4 - Torx screw

- ☐ Release with the pin-cers - T10072- .
- ☐ When releasing screw, the lock cylinder housing fastening is unlocked
➔ [Item 1st \(page 55\)](#)
and can be pulled out of the external handle support
➔ [Item 5 \(page 54\)](#) .
- ☐ The screw [Item 4 \(page 54\)](#) can not be tightened if the lock cylinder housing is not placed. The locking ring may fall inside the door.
- ☐ Torque:



-Zamak handle mounting, 4.5 Nm-

- ☐ Torque: -PA6 30 GF handle mounting, 2.5 Nm-

5 - External handle support

- ☐ Remove the lock cylinder housing ➔ [page 55](#) .
- ☐ Remove the door handle ➔ [page 59](#) .
- ☐ Remove the door lining ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- ☐ Remove the sealing membrane in the door handle area.
- ☐ Loosen screw ➔ [Item 6 \(page 54\)](#) , push external handle support a little backwards, and remove it from the door.

6 - Bolt

7 - Wrench

8 - Key with remote control

- ☐ Battery replacement ➔ [page 80](#)
- ☐ Code remote control for new or additional key ➔ [page 81](#)

9 - Door handle

- ☐ Paint according to ➔ Paint Manual - Repairing paintwork in plastic parts .
- ☐ Remove and install ➔ [page 59](#)

10 - Cover cap

- ☐ Paint according to ➔ Paint Manual - Repairing paintwork in plastic parts .



11 - Cylinder housing with or without lock cylinder

- ☐ Remove and install ➔ [page 55](#)
- ☐ fitted to the door lock and fastened with a screw.

12 - Support

13 - Central locking motor for driver/passenger door - V56/V57-

- ☐ for central locking
- ☐ fitted to the door lock ➔ [Item 2 \(page 54\)](#) and fastened with a screw

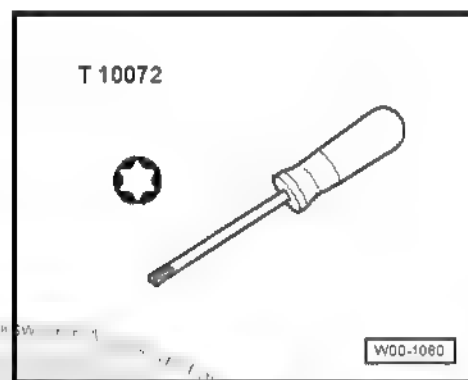
14 - Bolt

15 - Switch on external driver door handle for alarm system - F121-

1.10 Lock cylinder housing - remove and install

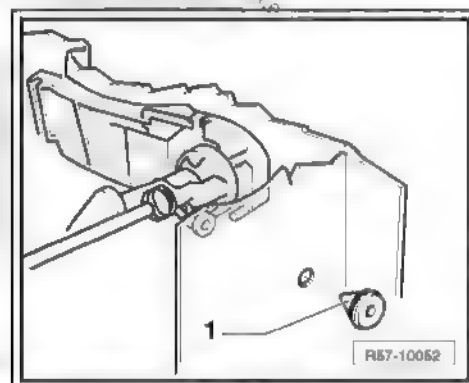
Special tools and workshop equipment required

- ◆ torque wrench - T10072-



Remove

- Disengage plug -1-





- Pull and hold the door handle -1-. Release the screw -3- with the pincers - T10072- and simultaneously press towards the external handle support. This releases the locking in the lock cylinder housing.



Note

If the screw is excessively released, the locking ring may detach from the external handle support and fall into the door as a result.

- Pull the lock cylinder housing -2- out of the external handle support, at a straight angle in relation to the door handle.

Install

Install is performed in the reverse sequence, observing the following:

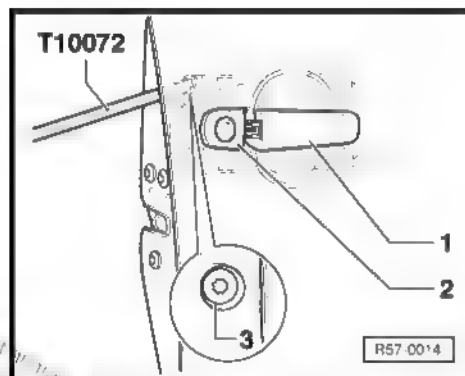
- Place the lock cylinder housing on the external handle support at a straight angle.
- Then, fasten the screw to the external handle support with the pincers - T10072-.

The door handle is again fitted to the lock cylinder housing when there is an audible click.



Note

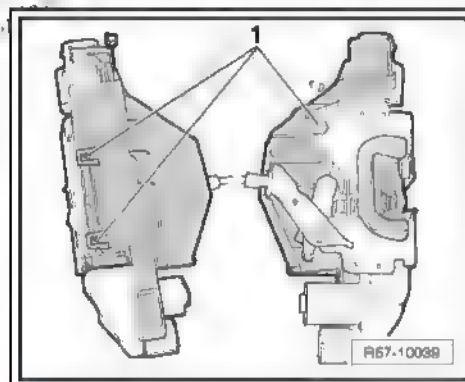
During the assembly, you must press the door handle and the lock cylinder housing against the door plate.



1.11 Central locking motor for driver / passenger door - V56/V57- - replace

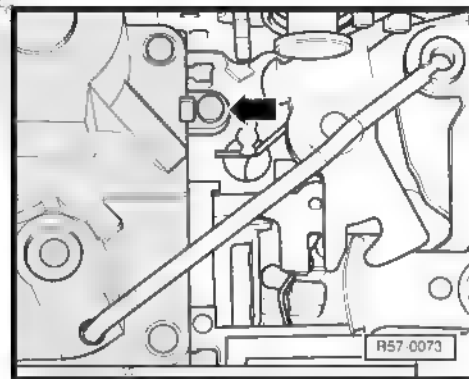
1.11.1 Remove

- Remove the door lock ➔ [page 64](#).





- Disengage locks -1- and separate the lock cover cap.
- Remove screw -arrow- that fastens the motor.
- Disengage and remove the motor operating rod.



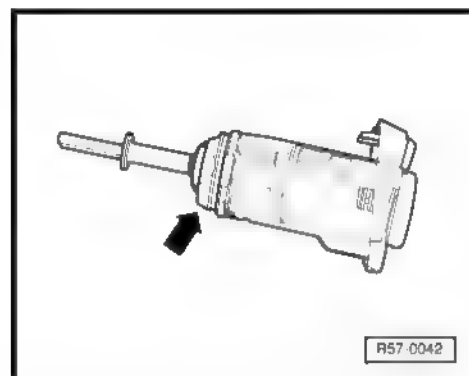
1.11.2 Install

- Installation is performed in the reverse sequence to the removal.

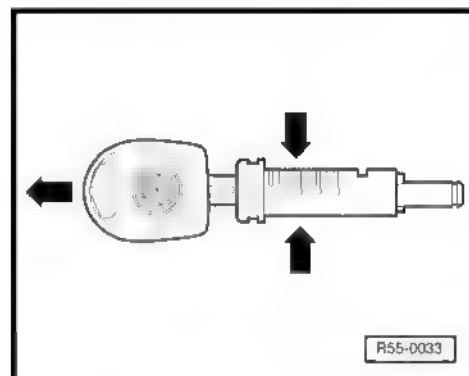
1.12 Cylinder housing - disassemble and assemble

1.12.1 Disassemble

- Remove the lock cylinder housing ⇒ [page 55](#).
- Insert the key in the cylinder.
- Press key towards cylinder
- Remove the lock and disengage the operating lever -arrow-.
- Remove the rings, the spring and the cylinder guide
- Remove cylinder along with key from housing.
- Clean the cylinder, removing all the dirt and grease remains.



- Manually press the gorges into the cylinder, and then carefully remove the key.
- Slowly loosen the cylinder, releasing the pressure from the gorge springs.



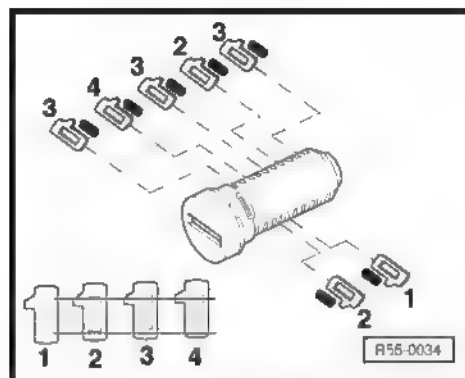


- Remove the gorges and the springs, marking their position in relation to the cylinder



Note

The gorges are identified by numbers from 1 to 4 (it is also possible to identify them through colors), mark the sequence, in the example - 2 3 1 4 3 2 3, or 2 1, on the lower section, and 3 4 3 2 3 on the upper section.



1.12.2 Assembling



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

- Place the springs and gorges in the correct position (sequence).



Note

During the operation, lubricate gorges and the cylinder with multipurpose grease ⇒ Chemicals Manual or -G 052 745 A3-.

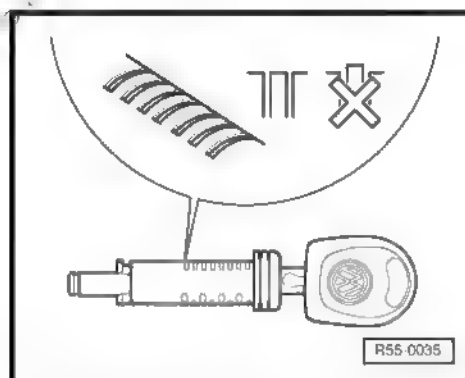
- When assembling, it is possible to combine gorges depending on the vehicle key, in case of cylinder replacement. To do so, follow the steps below:
- Starting from the last position of the cylinder groove, place the spring and gorge number 1. Introduce the key and observe the position of the groove with regards to the cylinder.
- If the upper gorge section is aligned with the cylinder housing -arrow-, then gorge number 1 is the correct one for this position. Otherwise, place gorge number 2 and so forth until finding the one that is aligned with cylinder when the key is inserted.



Note

Repeat the operation for all other gorge positions in the cylinder. Mark the position (sequence) of the gorges in relation to the cylinder.

- Install the cylinder guide on the housing
- Insert the cylinder into the guide.
- Position the spring and the rings.
- Install the operating lever.
- Install the lock.
- Install the lock cylinder on the handle ➔ [page 57](#) .
- Install the external handle ➔ [page 59](#) .





1.13 Cylinders and keys (Specific information for Brazil) - request

The key may be requested to the parts department with the original key mechanical code. For this purpose, follow the instructions in the Parts Circular Letter, number 156, of June 2004.

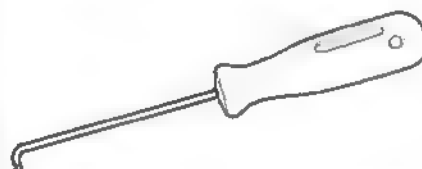
Full cylinders may be requested via fax number (5511) 4347-3652, by sending every information about the vehicle (chassis number, original key mechanical code, etc.)

1.14 External door handle, remove and install

Special tools and workshop equipment required

- ◆ Assembly tool - T 10389- or Assembly tool - T 02005-

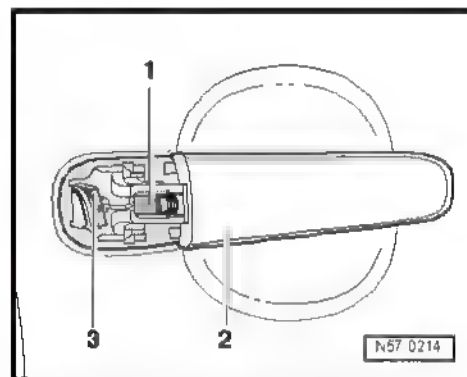
T02005



Q00-10046

1.14.1 Remove

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Unglue door sealing membrane from the upper section.
- Remove the lock cylinder housing ⇒ [page 55](#) .
- Disengage the clip -1- from the door handle -2-.
- Disengage the door handle -2- from the door panel.





1.14.2 Install



Note

Before installation begins, the spring -2- must be positioned so that the handle has no clearance when activated. To do so, follow instructions below.

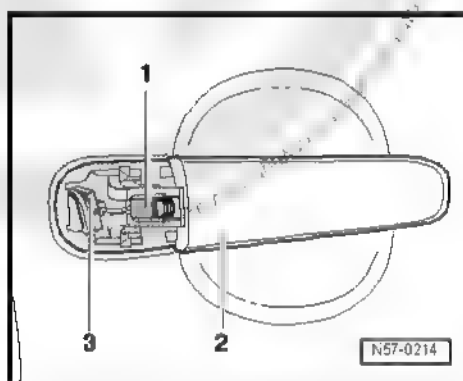
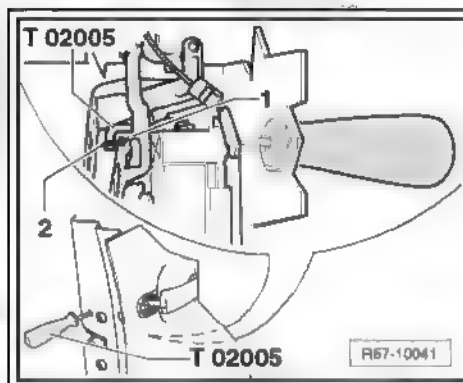
- Remove lock fastening screw (upper side lining) where assembly tool - T 10389- or assembly tool - T 02005- shall be inserted
- Introduce assembly tool - T 10389- or assembly tool - T 02005- in lock fastening hole.
- For better vision, light the internal door section with a lamp.
- Fit spring -2- to operating lever -1-.
- Fit the door handle -2- to the door panel.
- Pull the clip -1- inside the plate cut and fit to the door handle.



Note

When assembling the clip, the latch operating lever -3- cannot be pulled and the door handle -2- must be pressed against the door panel.

- Install the lock cylinder housing ⇒ [page 55](#) .



1.15 External door handle - replace

1.15.1 Remove

- Remove the external handle ⇒ [page 59](#) .

1.15.2 Install

- Paint the handle ⇒ Paint manual - Repairing paintwork in plastic parts .
- Installation is performed in the reverse sequence to the removal.

1.16 Door lock - remove and install

Special tools and workshop equipment required

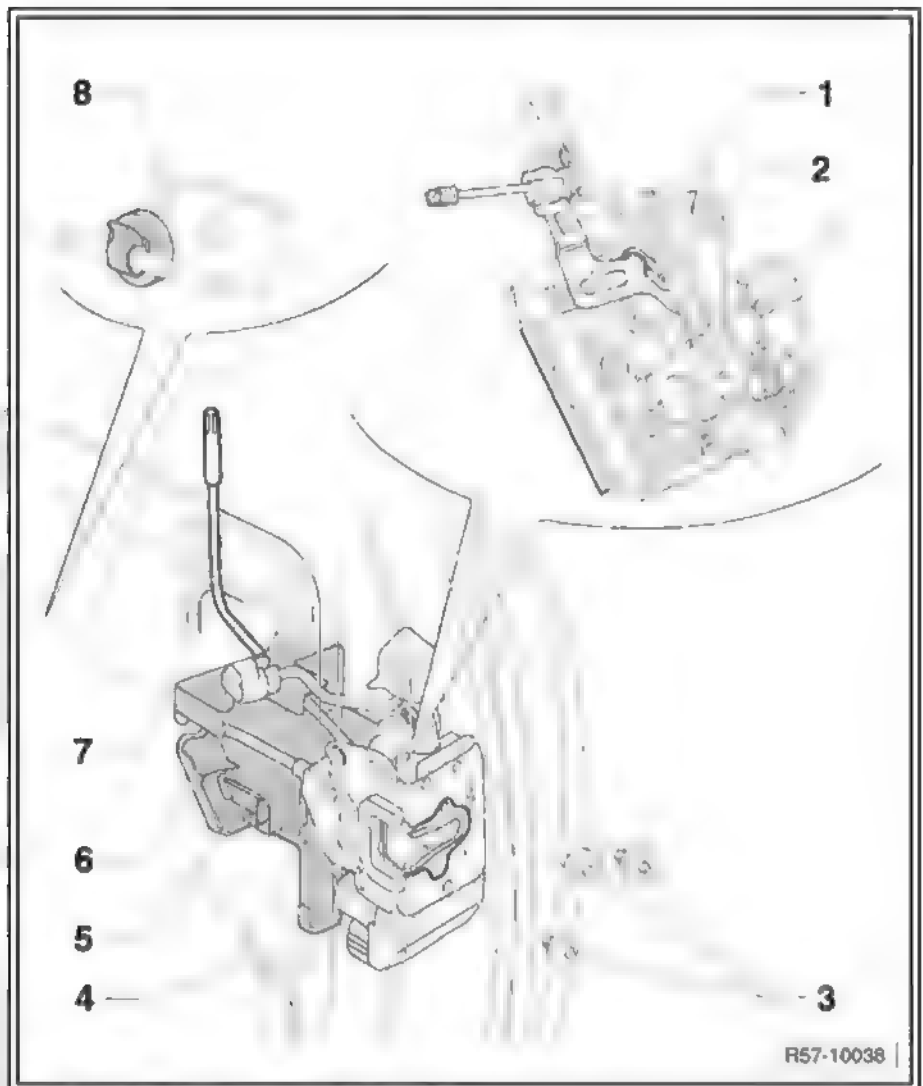
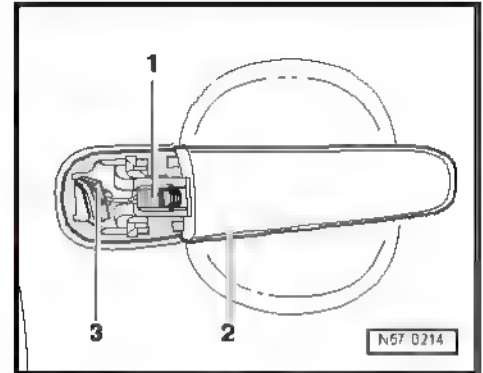
- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





1.16.1 Remove

- With the door window closed, remove the front door lining → General body repairs, interior; Rep. gr. 70; Lining / insulation
- Detach door sealing membrane from the upper section.
- Remove the lock cylinder housing → [page 55](#).
- Disengage the clip -1- from the door handle -2-.



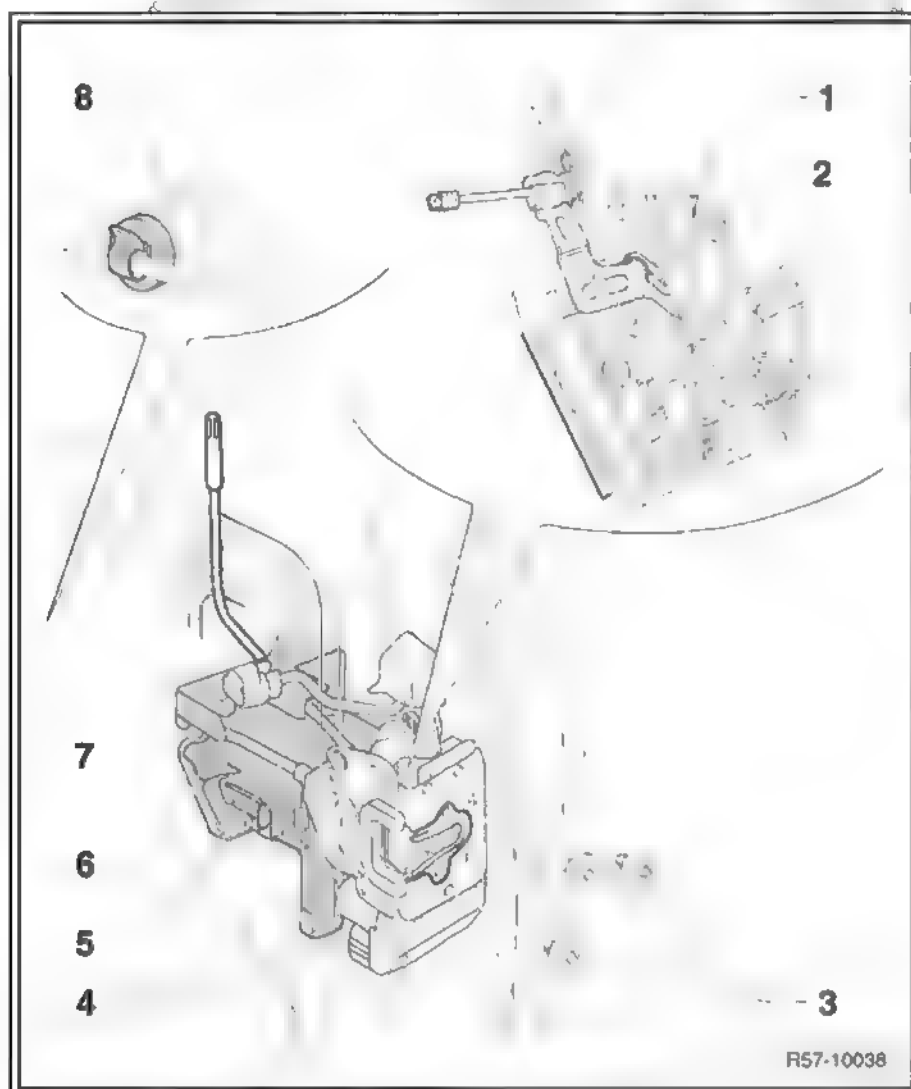
- Disengage door operating cable -5- from clip -8- (LAM market only)



- Disconnect the connector from the central locking motor for driver's/passenger's door - V56/V57- -4-
- Disengage connector from the alarm system harness-6-
- Remove the fastening screws -3- from the door lock and remove the lock through the assembly opening.

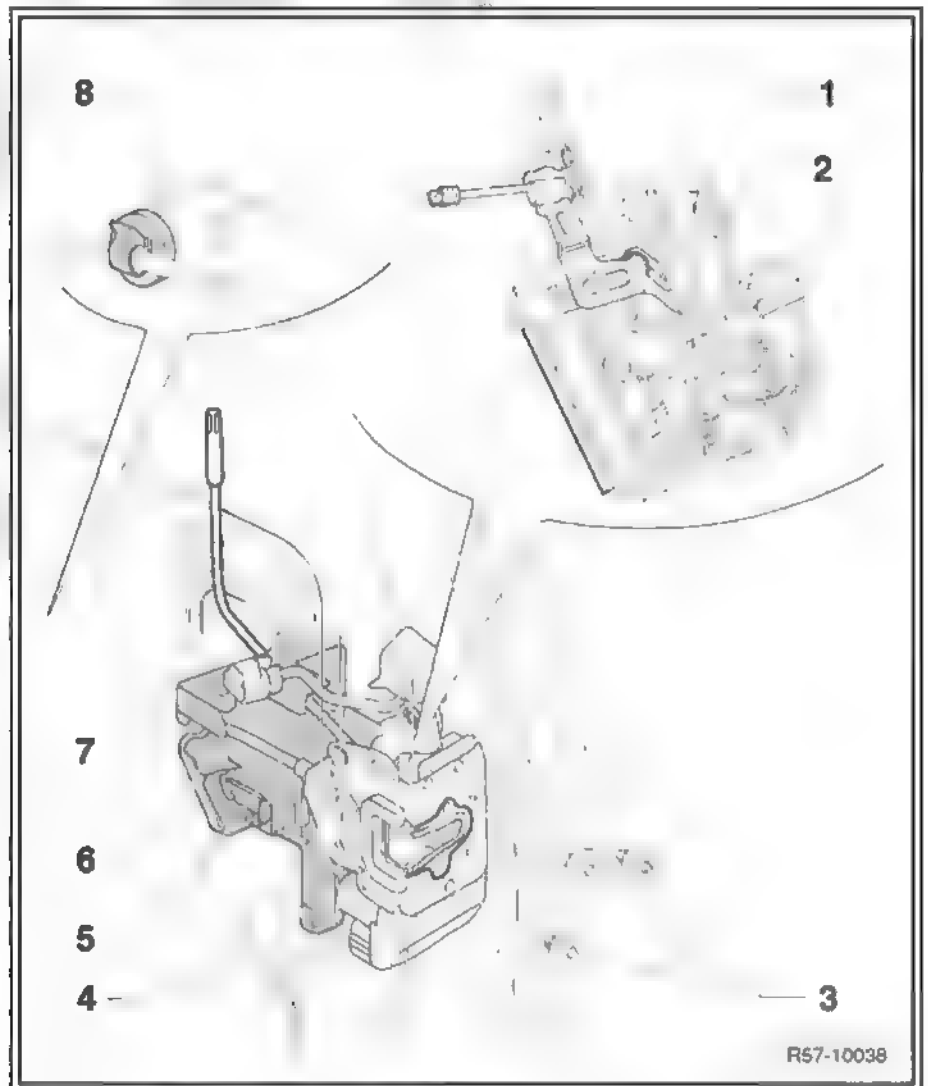
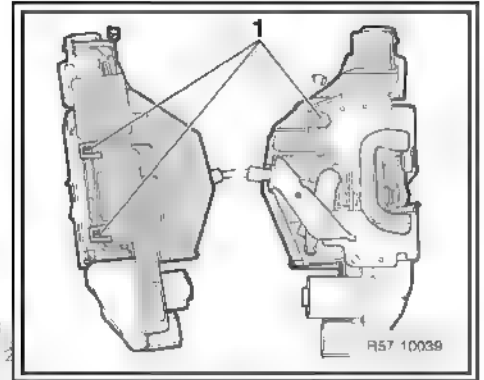
1.16.2 Install

- Install lock operating cable -5-
- Fit the lock locking rod -7-





- Fit spring -1- to lock operating lever -2-
- Fit locks -1- and fasten the lock cover cap.



- Position the lock and install the fastening screws -3- of the door lock to a final torque of 4 Nm
- Disconnect the connector from the central locking engine for driver/passenger door - V56/V57- -4-.
- Connect connector of alarm system harness -6-



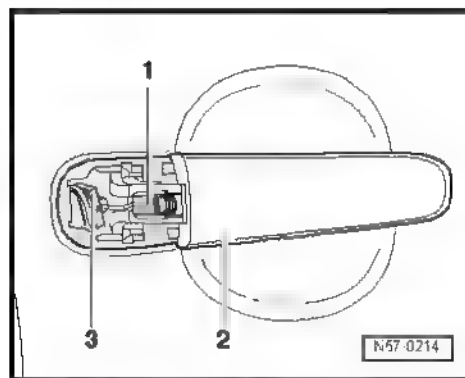
- Fit door operating cable -5- to clip -8- (Latin American market only).
- Pull the clip -1- inside the plate cut and fit to the door handle -2-.



Note

When assembling the clip, the lock operating lever -3- cannot be pulled and the door handle -2- must be pressed against the door plate.

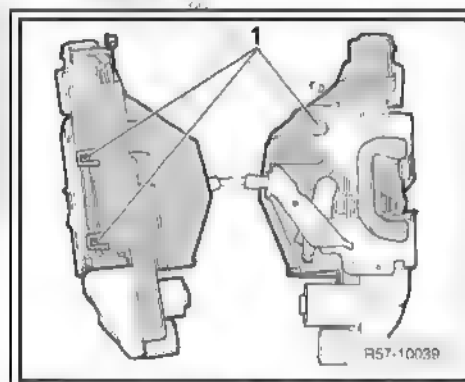
- Install the lock cylinder housing ⇒ [page 55](#).
- Install the door sealing membrane, pressing it with the pressure roll - 3356-.
- Install front door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations



1.17 Door lock - replace

1.17.1 Remove

- Remove the lock ⇒ [page 60](#).
- Disengage locks -1- and separate the lock cover cap.
- Disengage and remove the lock locking rod.
- Remove lock operating cable ⇒ [page 64](#).
- Remove central locking motor for driver/passenger door - V56/ V57- , if any.
- Remove switch on external driver door handle for alarm system - F121- , if any.



1.17.2 Install

- Installation is performed in the reverse sequence to the removal.

1.18 Lock Bowden cable - replace

Special tools and workshop equipment required

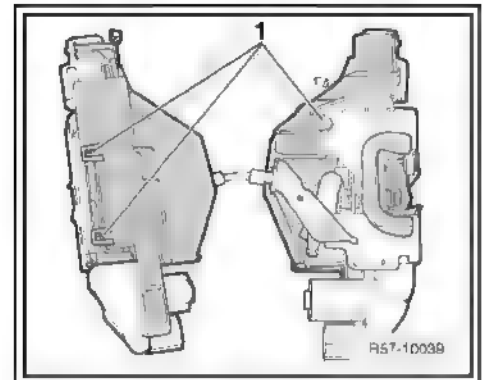
- ◆ Pliers - VW 5161A-



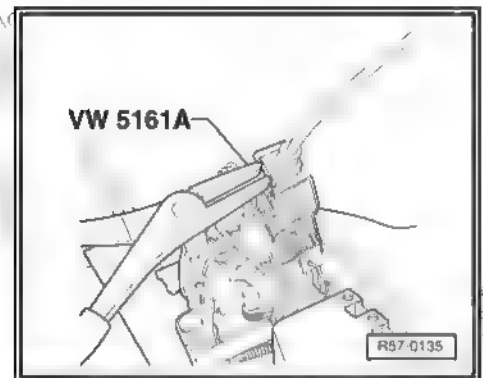


1.18.1 Remove

- Remove the door lock ➔ [page 60](#) .
- Disengage locks -1- and separate the lock cover cap.
- Disengage bushing cable end.

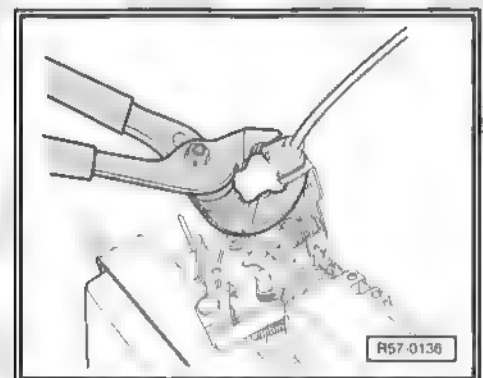


- Slightly open cable fitting mounting with pliers - VW 5161A- A
- Disengage the cable and remove it.

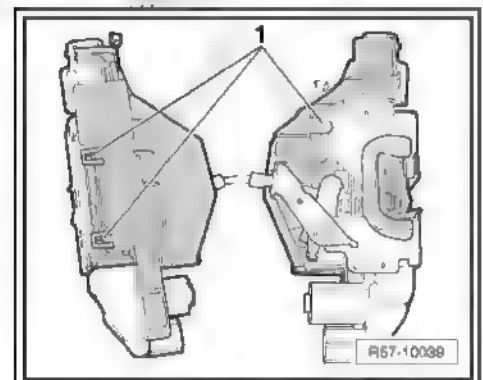


1.18.2 Install

- Fit cable to lock fitting support.
- Fit cable end to bushing.



- Slightly tighten cable fitting support with pliers.
- Fit locks -1- of lock cover cap.
- Install door lock ➔ [page 60](#) .

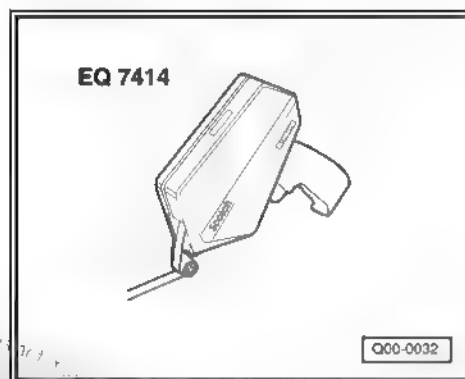




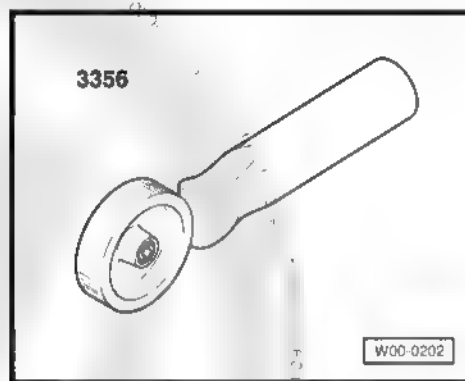
1.19 Door sealing membrane - remove and install

Special tools and workshop equipment required

- ◆ Transferable adhesive tape applicator - EQ 7414-



- ◆ Pressure roll - 3356-



1.19.1 Remove



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

- Remove the door lining ⇒ *General body repairs, interior; Rep. gr. 70* ; Lining / insulation - Door linings - remove and install.



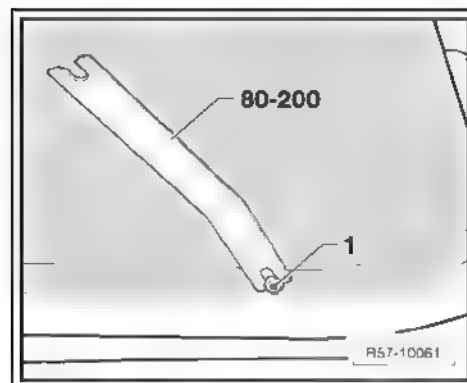
- Remove the adhesive tapes that fasten the membrane to the lock operating cable and wiring harnesses
- Remove bushings -1- with the ejector lever - 80-200- .
- Detach the sealing membrane and remove it



Note

Write down on the membrane the number of times it has been removed, 1st, 2nd or 3rd time.

- Remove any remaining adhesive from the internal door panel using the cleaning solution - D 009 401 04- .



Note

Moisten a cloth with the cleaning solution - D 009 401 04- and gently apply it over the affected area. Allow the product to work for a moment and then rub towards the centre starting from the edges. Repeat the operation if necessary. Next, rub the surface with a cloth until it is completely dry.

1.19.2 Install



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"



Note

- ◆ Polypropylene film with thickness of $0,2 \pm 0,02$ mm. Adhesion strength $\geq 4,5$ N/cm.
- ◆ The membrane has an sensitive acrylate-based adhesive coating that ensures it can be removed up to 3 times without affecting the adhesive performance. If the layer of adhesive is damaged, i.e., at 4th removal, install the membrane by using the transferable adhesive tape as described below.
- ◆ The membrane may be reinstalled if there is no damage such as stretching or wrinkles which can fatally compromise the seal against water and dust
- ◆ Apply transferable adhesive tape to the internal door panel (membrane adhesion area) with the transferable adhesive tape applicator - EQ 7414- , in case of loss of membrane adherence.
- Install the membrane by passing the cable and harnesses through the holes and paste it to the internal door panel
- Press the door sealing membrane with the pressure roll - 3356-
- Fasten the sealing membrane to the lock operating cable and wiring harnesses.



Note

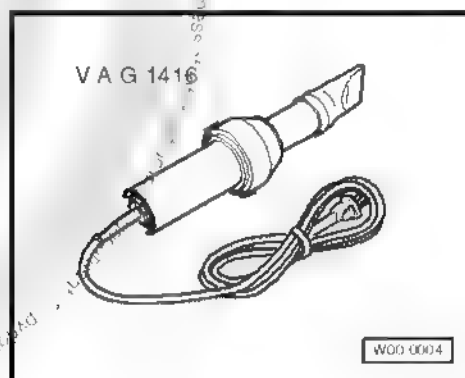
Self-adhesion felts are placed under the membrane to eliminate vibration and noise from the membrane due to the flow of air. Replace them when replacing the membrane.

- Install the door lining ⇒ General body repairs, interior; Rep gr. 70 ; Lining / insulation - Door linings - remove and install .

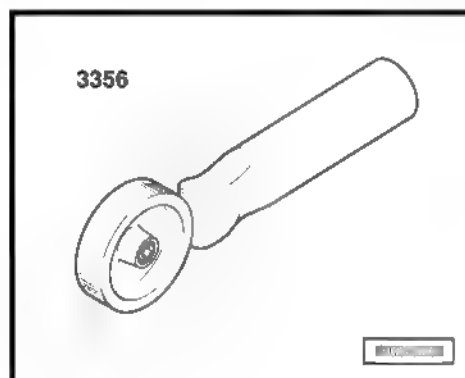
1.20 Door sealing packings - assembly overview

Special tools and workshop equipment required

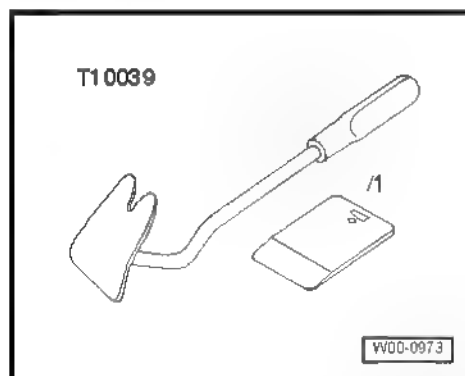
- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



- ◆ Wedge - T 10039/1-





1 - Double-sided tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.
- ☐ when assembling a new external packing, remove double-sided tape liner.

2 - External door trim

- ☐ self-adhesive
- ☐ Remove and install
⇒ [page 69](#)

3 - Internal lid trim

- ☐ covered on lower section by threshold trim
- ☐ Remove and install
⇒ [page 71](#)

4 - Threshold trim

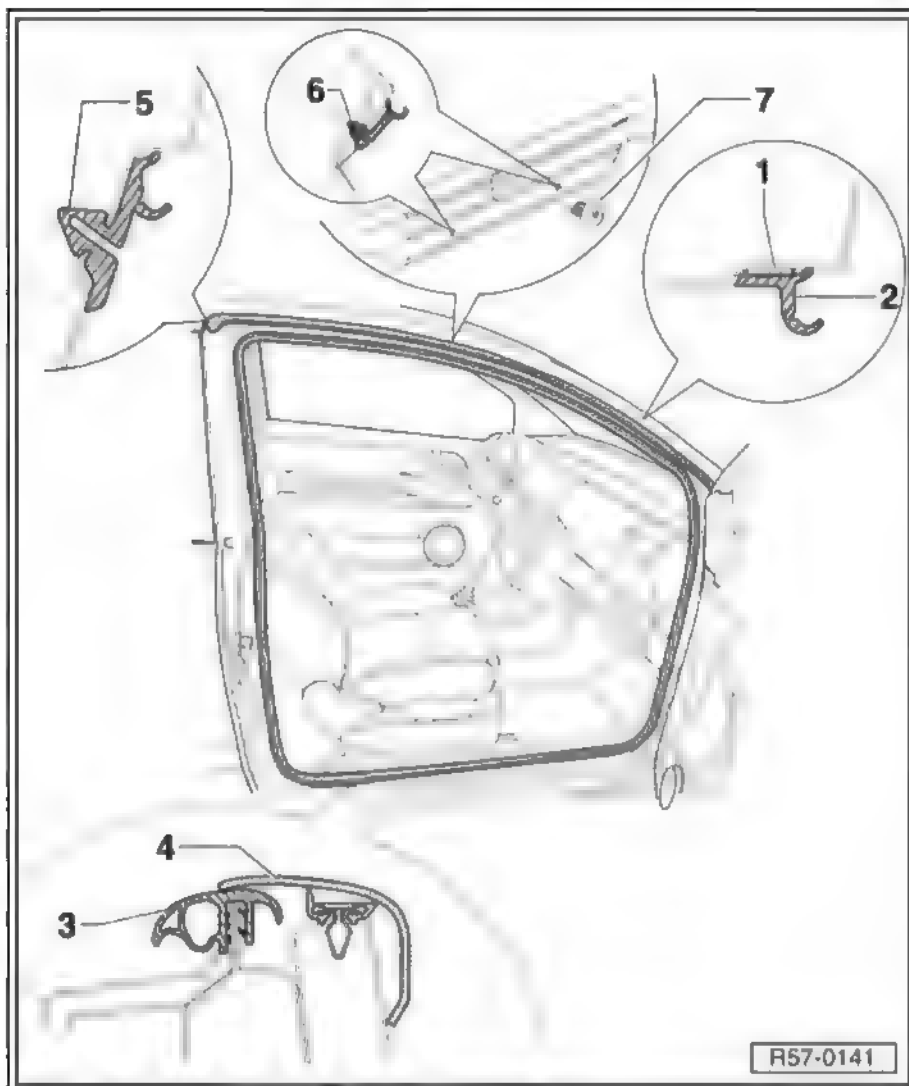
- ☐ remove and install ⇒
General body repairs,
interior; Rep. gr. 68 ; In-
ternal equipment

5 - Door external packing fitting (rear section)

6 - Door external packing fitting (rack area)

7 - Pin

- ☐ under pressure ► 02.05
- ☐ threaded 03.05 ►



1.21 External door packing - remove and install

1.21.1 Remove

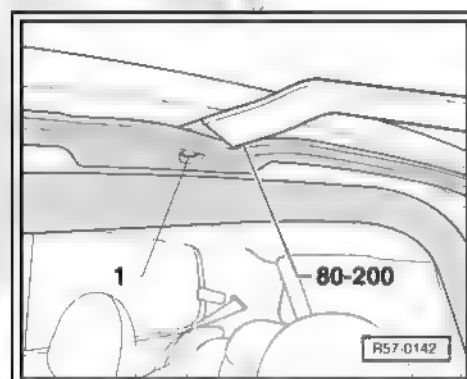
- Remove fastening pin with ejector lever - 80-200-



Note

- ◆ Removable with ejector lever - 80-200- only for vehicles manufactured until 02.05. Pin for vehicles manufactured from 03.05 is threaded.
- ◆ For vehicles produced as of chassis C4103637, the rubber tab fastened by fastening pin - 1- no longer exists.

- Heat up trim with the hot air blower - VAG 1416-.
- Detach trim using wedge - T 10039/1-.





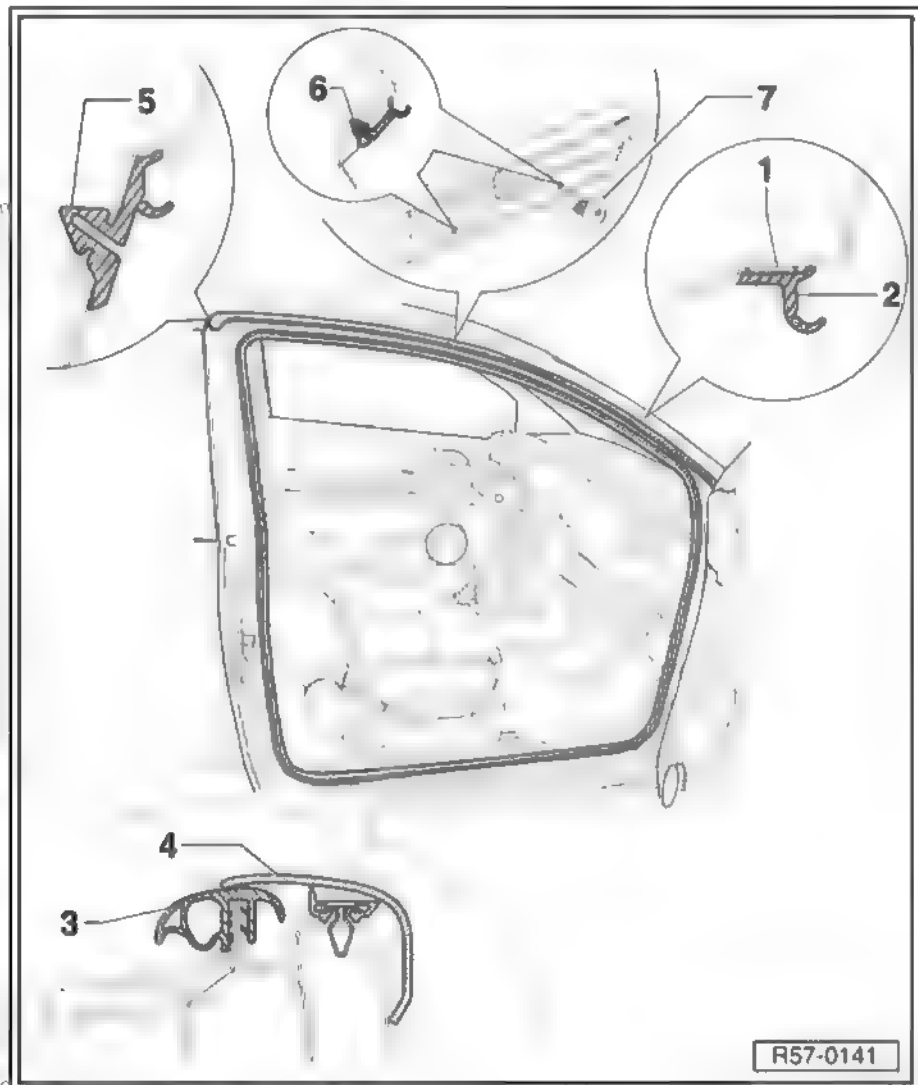
1.21.2 Install



WARNING

- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*

- Clean door frame in the adhesion area with adhesive remover - D 002 000 10-, then apply cleaning solution - D 009 401 04-. Dry the section with a dry cloth.
- Heat up the trim adhesive tape and door frame in the assembly section with the hot air blower - VAG 1416- at a temperature of 30 - 40 °C.



- Press packing -6- fitting and then press packing -5- fitting onto door frame holes.
- Remove the double-sided tape liner -1- and glue trim by firmly pressing it (above 10 N) with a pressure roll - 3356- . Only move the pressure roll in one direction



Note

Do not move it back and forth

- Install pin -7-.



Note

- ◆ *For vehicles produced as of chassis C4103637, the rubber tab fastened by fastening pin -7- no longer exists*
- ◆ *After assemble, the door must be kept open for a minimum period of 30 minutes so that the door's pressure on packing do not lead to premature packing detaching*

1.22 Internal door trim - remove and install

1.22.1 Remove

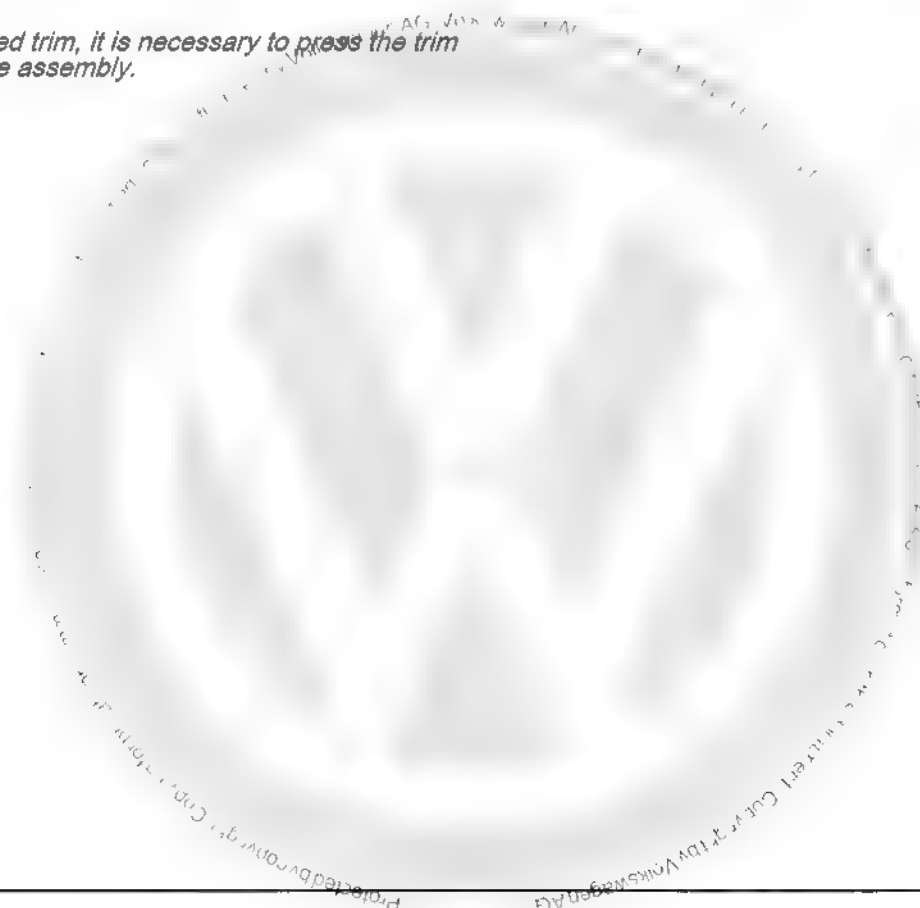
- Remove front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Internal Equipment .
- Disengage and remove the trim.

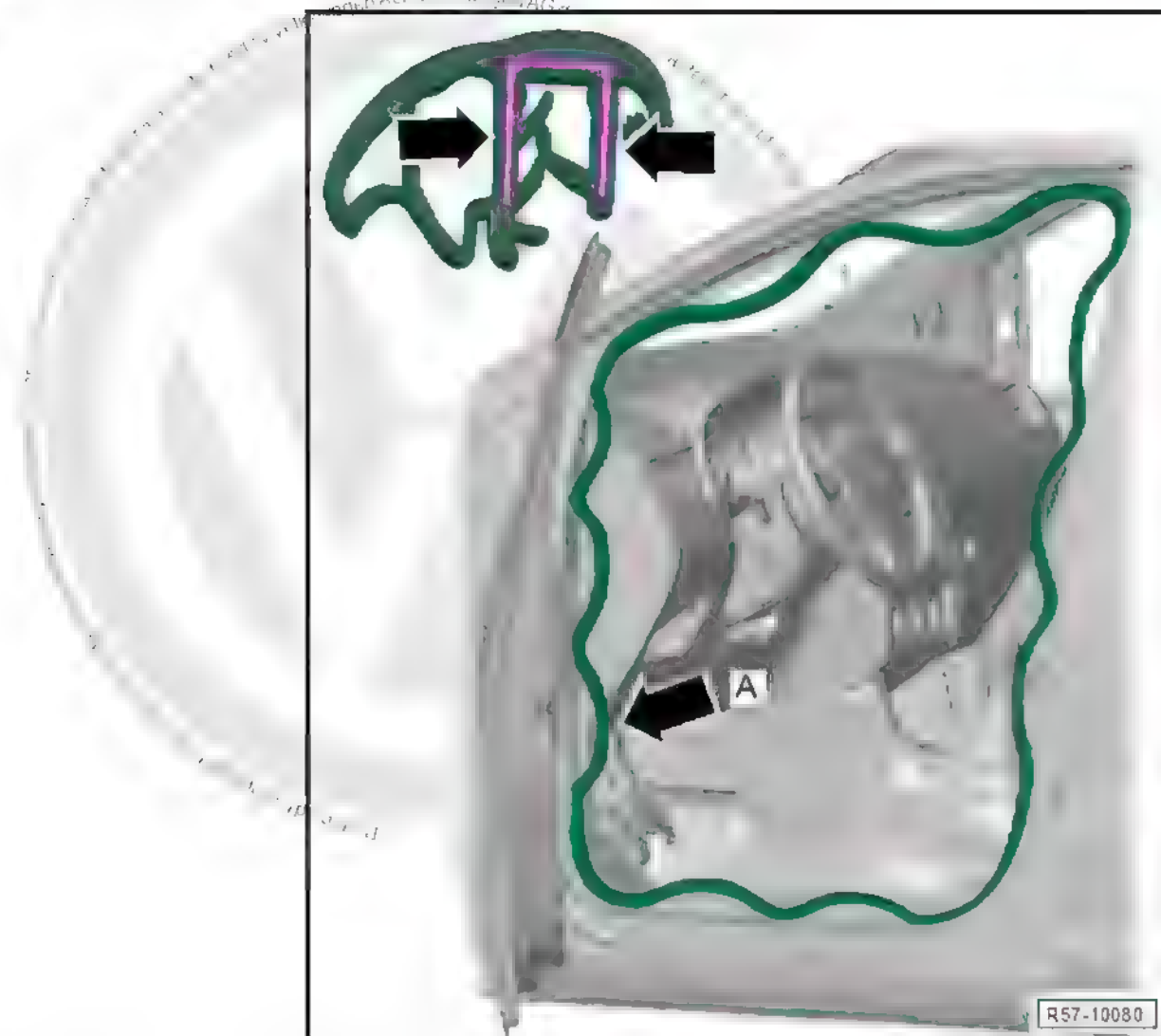
1.22.2 Install



Note

- ◆ *The vulcanized splice of the packing shall be mounted at the same height of the lock operating lever in the bonnet -arrow A-.*
- ◆ *For partially removed trim, it is necessary to press the trim sides -arrow- before assembly.*





- Manually engage the trim, initially in the door crest, and engage the remaining trim spots distributing trim tension.
- Slightly press the trim with a rubber hammer.
- Install front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Internal Equipment .

1.23 Cylinders and keys (Specific information for Brazil) - request

The key may be requested to the parts department with the original key mechanical code. For this purpose, follow the instructions in the Parts Circular Letter, number 156, of June 2004.

Full cylinders may be requested via fax number (5511) 4347-3652, by sending every information about the vehicle (chassis number, original key mechanical code, etc.)



2 Central locking

2.1 Central locking installation location overview - 2-door

1 - Bonnet contact switch for Anti-theft alarm system - F120-

- ☐ Installation location: on the right side of the engine compartment.

2 - Connection

- ☐ Location: A-pillar
- ☐ turn halves to disengage connector.

3 - Front passenger side window regulator motor - V148-

- ☐ remove:
 - Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Remove the window regulator motor.

4 - Right front door lock

- ☐ Replaceable Central locking system motor for passenger door - V303-.
- ☐ remove:
 - Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Remove the door lock
⇒ [page 60](#) .

5 - Rear lid release motor - V139-

- ☐ fastened to bonnet support
- ☐ Remove and install ⇒ [page 33](#)

6 - Rear door latch

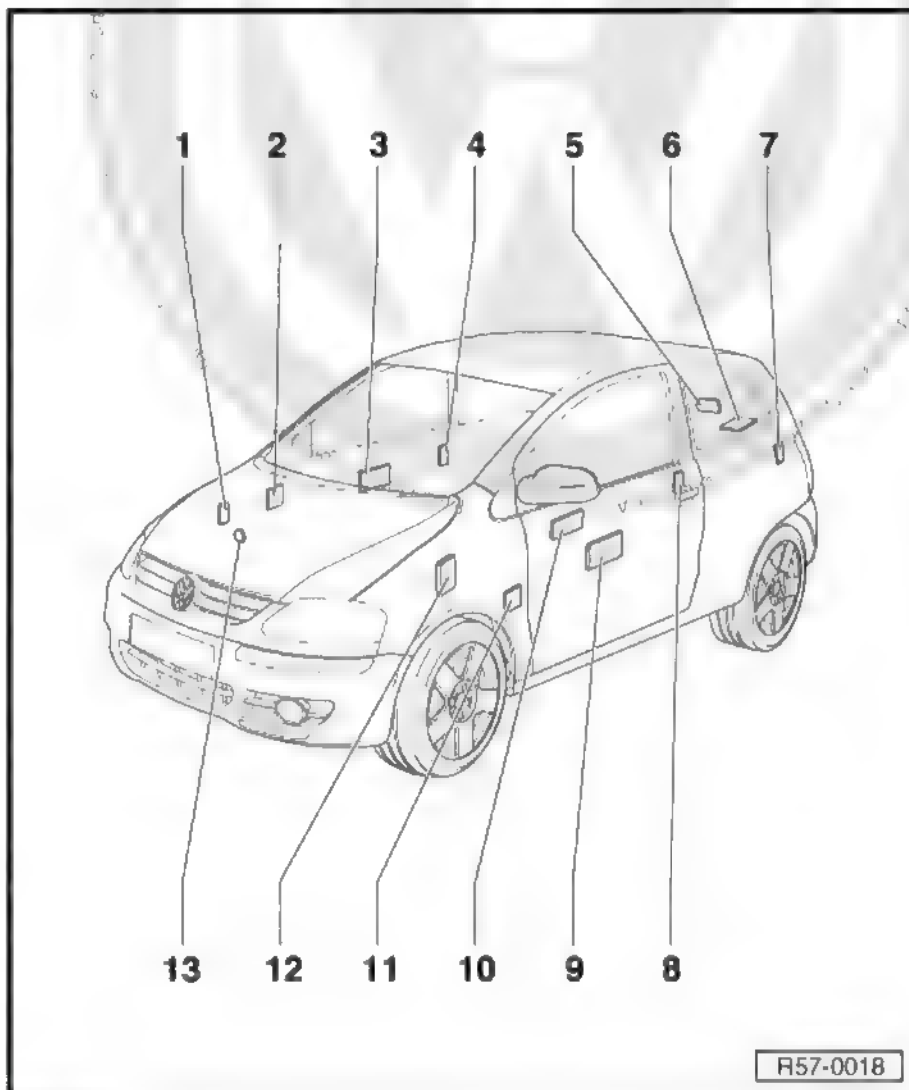
- ☐ fastened to bonnet
- ☐ Remove and install ⇒ [page 32](#)

7 - Connection

- ☐ Location: on the rear door, **behind the rear door lining**
- ☐ Remove and install the rear door lining → General body repairs, interior; Rep. gr. 70 ; Linings / insulations

8 - Left front door lock

- ☐ Replaceable Central locking system motor for driver door - V302-.
- ☐ remove:
 - Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Remove the door lock → [page 60](#) .



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9 - Driver side window regulator motor - V147-

- ☐ remove
 - Remove the door lining ➤ General body repairs, interior; Rep. gr. 70 , Lining / insulation
 - Remove the window regulator motor

10 - Command unit

- ☐ Right front window activation switch on driver's side - E81-
- ☐ Mirror adjustment switch - E43-
- ☐ Window activation switch on passenger's door - E107-
- ☐ installed on door lining
- ☐ remove
 - Remove the door lining ➤ General body repairs, interior; Rep. gr. 70 , Lining / insulation

11 - Connection

- ☐ Location: A-pillar
- ☐ turn halves to disengage connector.

12 - Central control unit for the convenience system - J393-

- ☐ assembled in a support in the central dashboard support
- ☐ Location: below dashboard at driver's side, and above the accelerator pedal (in vehicles with steering wheel at the right, above the clutch pedal).

13 - Alarm system horn - H8-

- ☐ Location: on the right side of the engine compartment



2.2 Central locking installation location overview - 4-door

1 - Bonnet contact switch for Anti-theft alarm system - F120-

2 - Connection

- ☐ Location: on the right side in the engine compartment
- ☐ Location: A-pillar
- ☐ turn halves to disengage connector.

3 - Front passenger side window regulator motor - V148-

- ☐ Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove the window drive motor

4 - Right front door lock

- ☐ Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove the door lock
⇒ [page 60](#)

5 - Connection

- ☐ Location: B-pillar
- ☐ To disconnect the connector, you must remove the protection bellows

6 - Rear right window regulator motor - V27-

- ☐ Door control unit in vehicles with convenience system
- ☐ Integrated to the window drive motor
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove Rear right window regulator motor - V27-

7 - Right rear door lock

- ☐ The electric central locking is integrated to the door lock module
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation

8 - Rear lid release motor - V139-

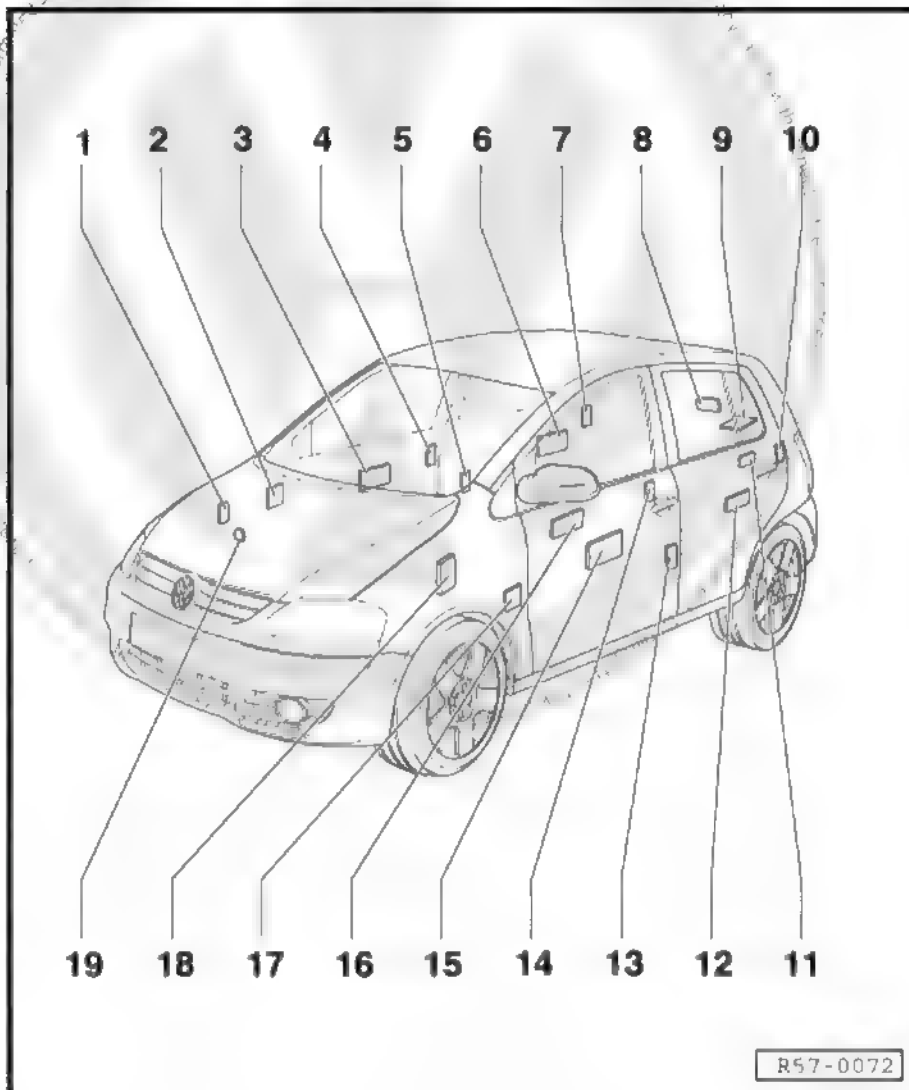
- ☐ Installed on a rear door support
- ☐ Remove and install → [page 33](#)
- ☐ Remove door latch → [page 32](#) .

9 - Bonnet latch

- ☐ Installed on bonnet
- ☐ Remove and install → [page 32](#)

10 - Connection

- ☐ Location: on the rear door, behind the rear door lining
- ☐ Remove the rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation



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11 - Left rear door lock

- ☐ The electric central locking is integrated to the door lock module
- ☐ Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove the door lock → [page 95](#) .

12 - Rear left window regulator motor - V26-

- ☐ Integrated to the window drive motor
- ☐ Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove the window activation motor → [page 176](#)

13 - Connection

- ☐ Location: B-pillar
- ☐ To disconnect the connector, you must remove the protection bellows

14 - Left front door lock

- ☐ The electric central locking is integrated to the door lock module
- ☐ Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove the door lock → [page 60](#)

15 - Driver side window regulator motor - V147-

- ☐ Door control unit in vehicles with convenience system
- ☐ Integrated to the window drive motor
- ☐ Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove the window activation motor → [page 171](#)

16 - Command unit

- ☐ Installed on door lining
- ☐ Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation

17 - Connection

- ☐ Location: A-pillar
- ☐ turn halves to disengage connector.

18 - Central control unit for the convenience system - J393-

- ☐ Assembled in a support in the central dashboard support.
- ☐ Installation location: below the dashboard, on the driver's side, and above the accelerator pedal (in vehicles with steering wheel at the right, above the clutch pedal)

19 - Alarm system horn - H8-

- ☐ Location: on the right side of the engine compartment



2.3 Central locking installation locations overview

1 - Bonnet contact switch for Anti-theft alarm system - F120-

2 - Connection

- ☐ Location: on the right side in the engine compartment
- ☐ Location: A-pillar
- ☐ turn halves to disengage connector.

3 - Front passenger side window regulator motor - V148-

- ☐ Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the window activation motor
⇒ [page 176](#)

4 - Right front door lock

- ☐ Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the door lock
⇒ [page 60](#)

5 - Connection

- ☐ Location: B-pillar
- ☐ To disconnect the connector, you must remove the protection bellows

6 - Rear right window regulator motor - V27-

- ☐ Door control unit in vehicles with convenience system
- ☐ Integrated to the window drive motor
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install
- ☐ Remove Rear right window regulator motor - V27-

7 - Right rear door lock

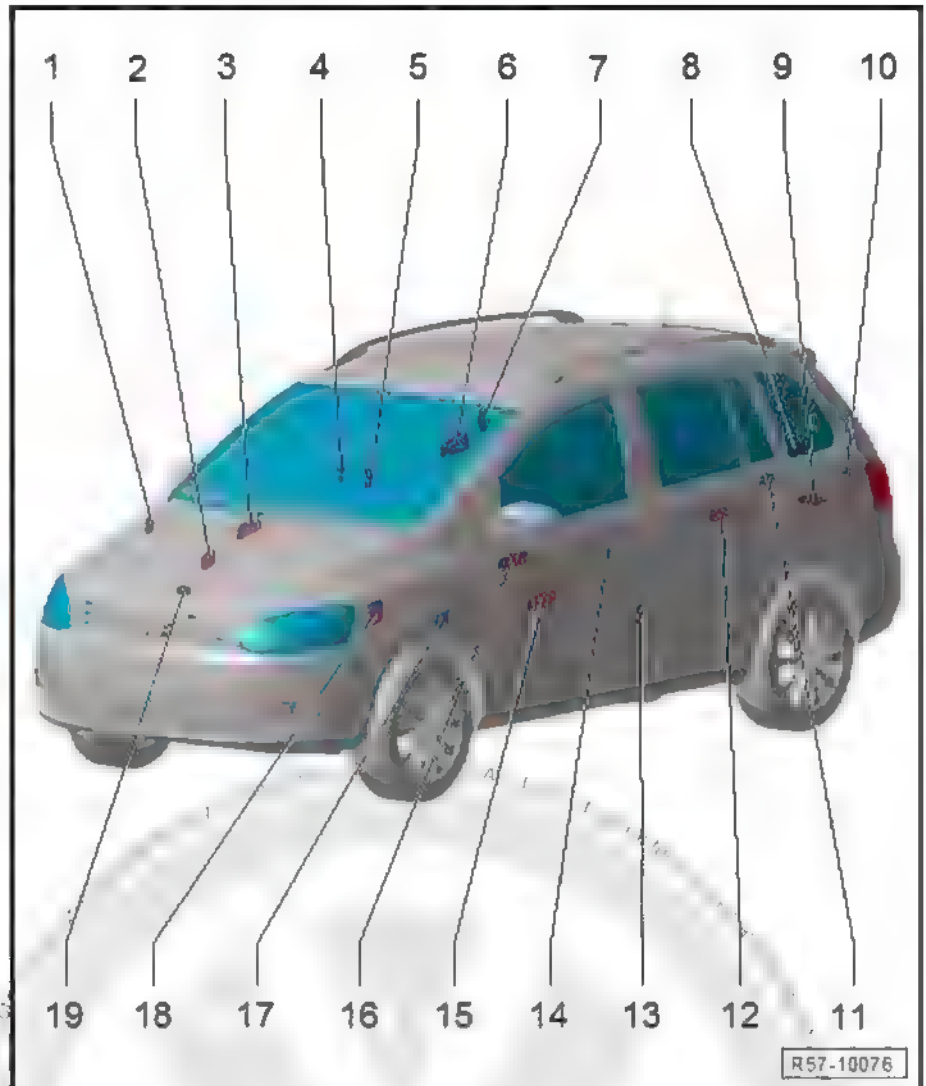
- ☐ The electric central locking is integrated to the door lock module
- ☐ Remove the door lining ⇒ General body repairs, interior, Rep. gr. 70 , Lining / insulation - Door linings - remove and install .

8 - Rear lid release motor - V139-

- ☐ Installed on a rear door support
- ☐ Remove and install
- ☐ Remove door latch ⇒ [page 42](#) .

9 - Bonnet latch

- ☐ Installed on bonnet
- ☐ Remove and install ⇒ [page 42](#)





10 - Connection

- ☐ Location: on the rear door, behind the rear door lining
- ☐ Remove and install the Rear lid lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Rear lid linings - remove and install

11 - Left rear door lock

- ☐ The electric central locking is integrated to the door lock module
- ☐ Remove the door lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the door lock ➤ [page 95](#)

12 - Rear left window regulator motor - V26-

- ☐ Integrated to the window drive motor
- ☐ Remove the door lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the window activation motor ➤ [page 176](#)

13 - Connection

- ☐ Location: B-pillar
- ☐ To disconnect the connector, you must remove the protection bellows

14 - Left front door lock

- ☐ The electric central locking is integrated to the door lock module
- ☐ Remove the door lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the door lock ➤ [page 60](#)

15 - Driver side window regulator motor - V147-

- ☐ Door control unit in vehicles with convenience system
- ☐ Integrated to the window drive motor
- ☐ Remove the door lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the window activation motor ➤ [page 171](#)

16 - Command unit

- ☐ Installed on door lining
- ☐ Remove the door lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .

17 - Connection

- ☐ Location: A-pillar
- ☐ turn halves to disengage connector.

18 - Central control unit for the convenience system - J393-

- ☐ Assembled in a support in the central dashboard support
- ☐ Installation location: below the dashboard, on the driver's side, and above the accelerator pedal (in vehicles with steering wheel at the right, above the clutch pedal)

19 - Alarm system horn - H8-

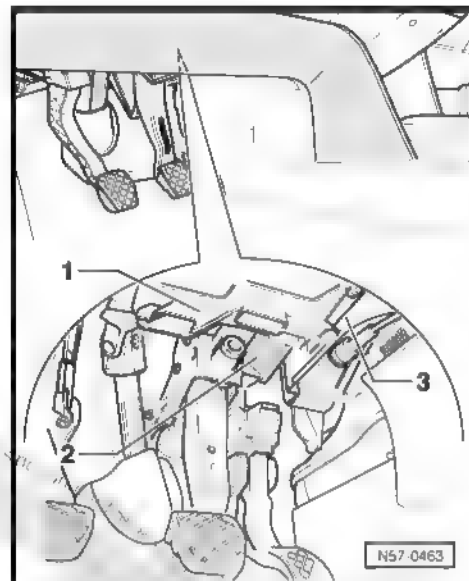
- ☐ Location: on the right side of the engine compartment



2.4 Central control unit for convenience system - J393- - remove

The command unit for convenience system -2- is located on a plastic support installed on the dashboard central support -3-.

- Remove the baffle -1- for the footwell area on the driver's side
⇒ Heating - ventilation; Rep. gr. 80 ; Ventilation .

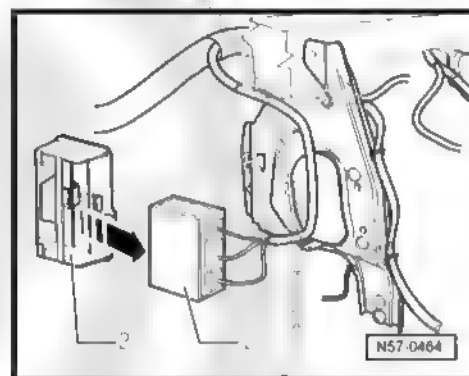


- Pull -arrow- the command unit for convenience system - J393- -1- out of support -2- and disconnect connector.



Note

- ◆ When the command unit for convenience system - J393- is replaced, it is necessary to codify the new unit, adapt the radio-commanded keys ⇒ [page 81](#) , and enable/disable available functions.
- ◆ Vehicle diagnostic, testing and information system - VAS 5051- , Vehicle diagnostic, testing and information system - VAS 5052- , Vehicle diagnostic, testing and information system - VAS 6150- Diagnostic cable - VAS 5051/6B- and Diagnostic cable - VAS 5052/3A- and Wireless diagnostic connector - VAS 5054A-



2.5 Remote-command key - assembly overview



1 - Remote control switches housing body

2 - LED

- ❑ This LED must light up when remote control is activated
- ❑ If LED does not light up when remote control is activated, it means battery discharged. It must be replaced.

3 - Print circuit and switches

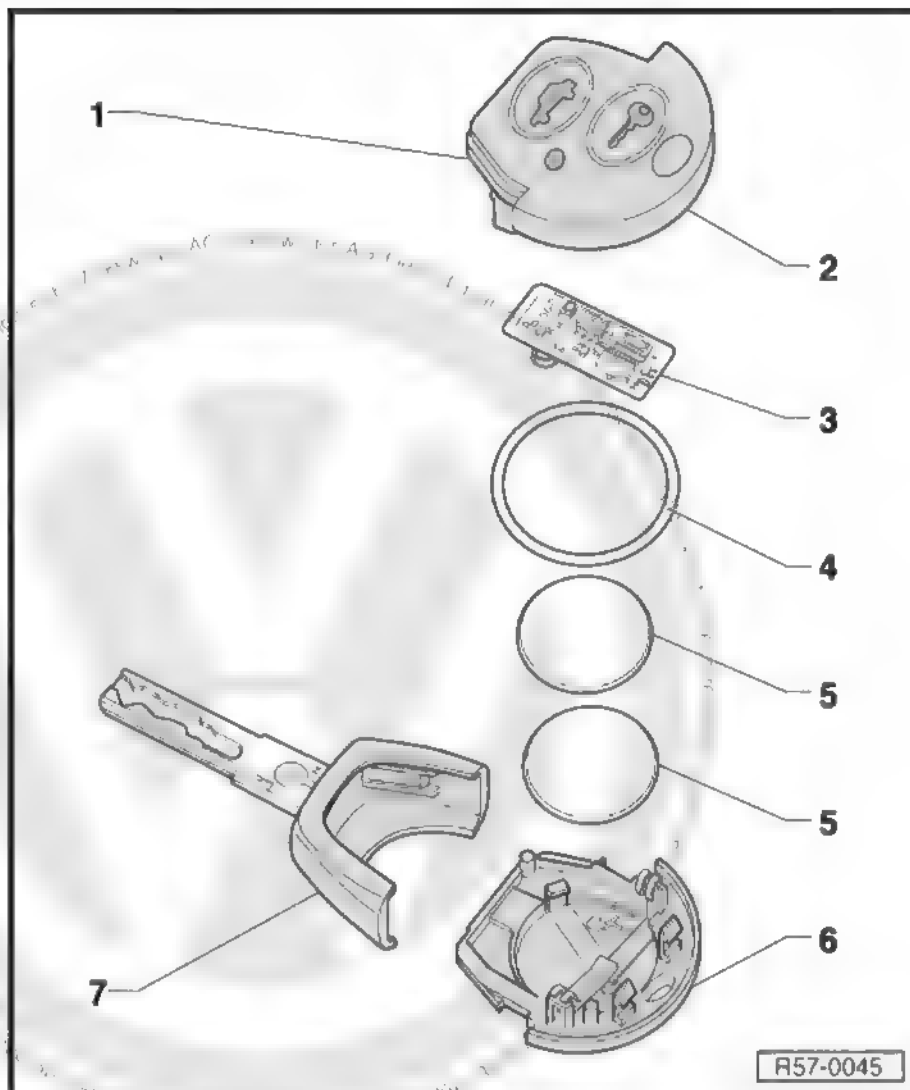
4 - Sealing ring

5 - Tablet battery

- ❑ two 3-V serial batteries
- ❑ As from 03.09, chassis 941409415 the remote control operates on one 3-V battery only
- ❑ Remove and install ⇒ [page 80](#)

6 - Battery housing body

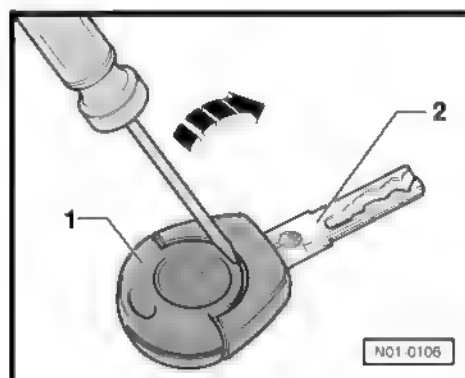
7 - Wrench



2.6 Batteries for remote-command key - remove and install

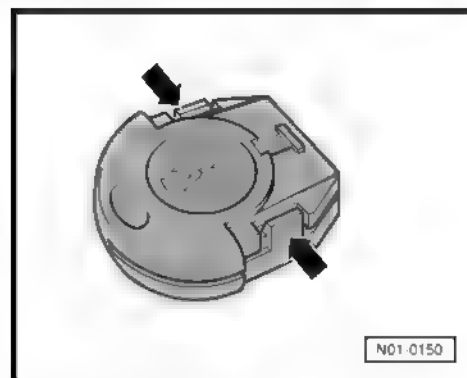
2.6.1 Remove

- Put a screwdriver on body opening -1-, opposite side from switches.

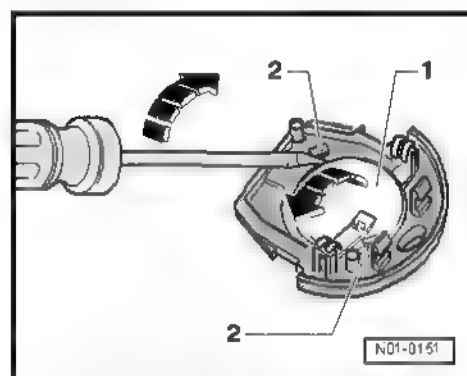




- Move screwdriver towards the arrow, and separate key bodies -2-.



- Unlock locks -arrows- with a screwdriver.
- Disengage upper battery -1- from supports -2- with a screwdriver towards the arrow.



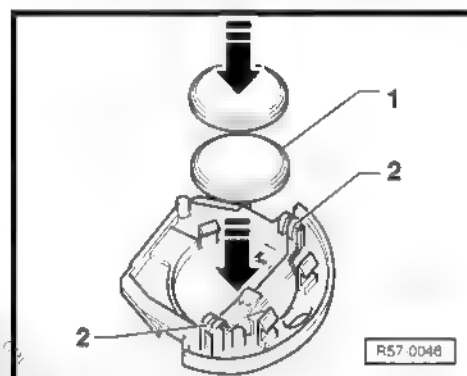
2.6.2 Install



Note

As from 03.09, chassis 94140941, the remote control operates on one 3-V battery only.

- Put the first battery -1- with positive pole up into the battery housing body. Then, put the second battery the same way as the first one until locks -2- lock.



Note

Pay attention to polarity and assembly position when installing the battery.

- Carefully press remote control switch housing body against the battery housing body so as to prevent damage to sealing.
- Fit key.

2.7 Adapting radio-commanded keys to centre control unit for convenience system - J393-



Special tools and workshop
equipment required

VAS 5051 	VAS 5052 
VAS 6150 	VAS 5051/6B 
VAS 5052/3A 	VAS 5054 A  Q97-10001

- ◆ Vehicle diagnostic, testing and information system - VAS 5051-
- ◆ Vehicle diagnostic, testing and information system - VAS 5052-
- ◆ Vehicle diagnostic, testing and information system - VAS 6150-
- ◆ Diagnostic cable - VAS 5051/6B-
- ◆ Diagnostic cable - VAS 5052/3A-
- ◆ Wireless diagnostic connector - VAS 5054A-



Adapting keys with remote control is performed with the Vehicle diagnostic, testing and information system - VAS 5052A / VAS 5051B- .

- Select, in the Vehicle diagnostic, testing and information system - VAS 5052A / VAS 5051B- , the "Assisted troubleshooting"
- Select the "Component selection" function through the **Skip** key, and sequentially the following menu options:
 - ◆ Body
 - ◆ Body assembly works
 - ◆ 01 - Self-diagnosis systems
 - ◆ Convenience system
 - ◆ Functions - Convenience system
 - ◆ Adapting keys with remote control



Note

For adaptation of radio-commanded keys to the immobilizer control unit - J362- , refer to ⇒ Electrical system; Rep. gr. 96 ; Switches, lights and internal lamps, alarm - Ignition key - adapt to immobilizer.

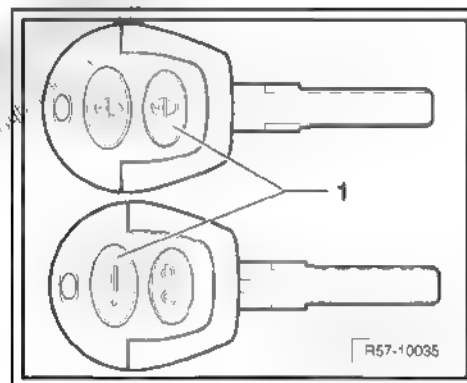
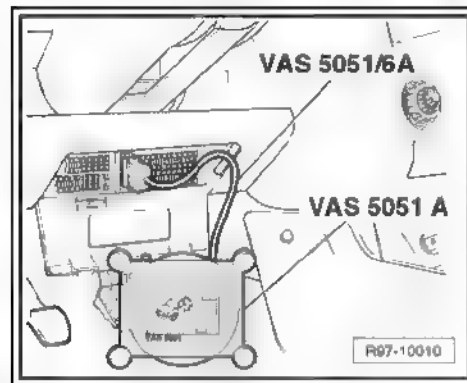
2.8 Key - synchronize

The key synchronization is required when some key is pressed out of the sphere of action of the system.

- Turn the ignition key on by using the backup key.
- Insert the key with remote control into the driver's side door cylinder. Turn it counterclockwise and keep it in this position.
- Press the key -1- continuously until achieving the synchronism which is noticed by the automatic locking and unlocking of the doors.

The Central control unit for convenience system - J393- stores until two synchronizations. In order to perform a third synchronization, it is required to reset the unit through Vehicle diagnostic, testing and information system - VAS 5052A / VAS 5051B- .

- ◆ "46 - Convenience system central module."
- ◆ "Function 10 - Adapting"
- ◆ "Channel 11", reset.





58 – Rear doors, door components

1 Rear passenger doors

1.1 Rear passenger doors - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

1 - Locking button

- ❑ Installed on the locking rod up to the buffer
- ❑ On -locked door- position, the upper end of button shall be 19 mm above the door lining. On -unlocked door-position, the upper end of button shall be 29 mm above the door lining.

2 - Locking rod

3 - Inversion lever

- ❑ Replace ⇒ [page 99](#)

4 - Command rod

5 - Internal door handle

- ❑ Remove and install ⇒ [page 91](#)

6 - Lock Bowden cable

- ❑ Remove and install ⇒ [page 100](#)

7 - Door lock

- ❑ Lubricate with low-temperature grease -G 052 745 A3-

8 - Screw (M6 x 10)

- ❑ Torque: 4 Nm

9 - Lock

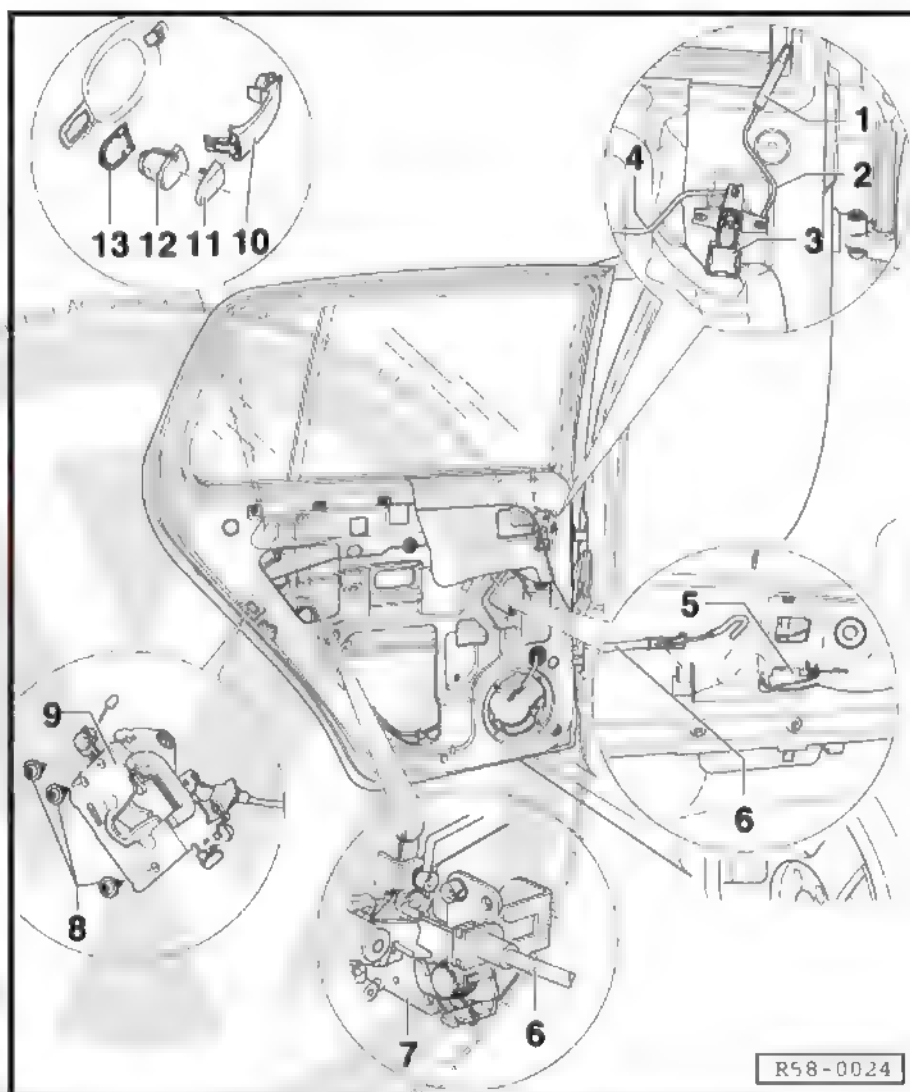
- ❑ Remove and install ⇒ [page 95](#)

10 - External handle

- ❑ Remove and install ⇒ [page 94](#)

11 - Cover cap

- ❑ Paint according to ⇒ [Paint Manual - Repairing paintwork in plastic parts](#)



R58-0024



12 - External handle housing

- ☐ Paint according to ➤ Paint Manual - Repairing paintwork in plastic parts .
- ☐ Remove and install ➤ [page 93](#)

13 - Support

Rear passenger doors - assembly overview - continued

1 - Bolt

- ☐ M 8
- ☐ Torque: 20 Nm + 1/4 (90°)
- ☐ They must be replaced whenever loosen or removed

2 - Bolt

- ☐ M 8
- ☐ Torque: 20 Nm + 1/4 (90°)
- ☐ They must be replaced whenever loosen or removed

3 - Multi-tooth screw

- ☐ M 8
- ☐ Torque: 20 Nm + 1/4 (90°)
- ☐ They must be replaced whenever loosen or removed

4 - Nut

- ☐ Torque: 14 Nm

5 - Hinge pin

6 - Door hinge

7 - Support

8 - Striker

- ☐ Adjust ➤ [page 90](#)

9 - Bolt

- ☐ Torque: 20 Nm

10 - Bolt

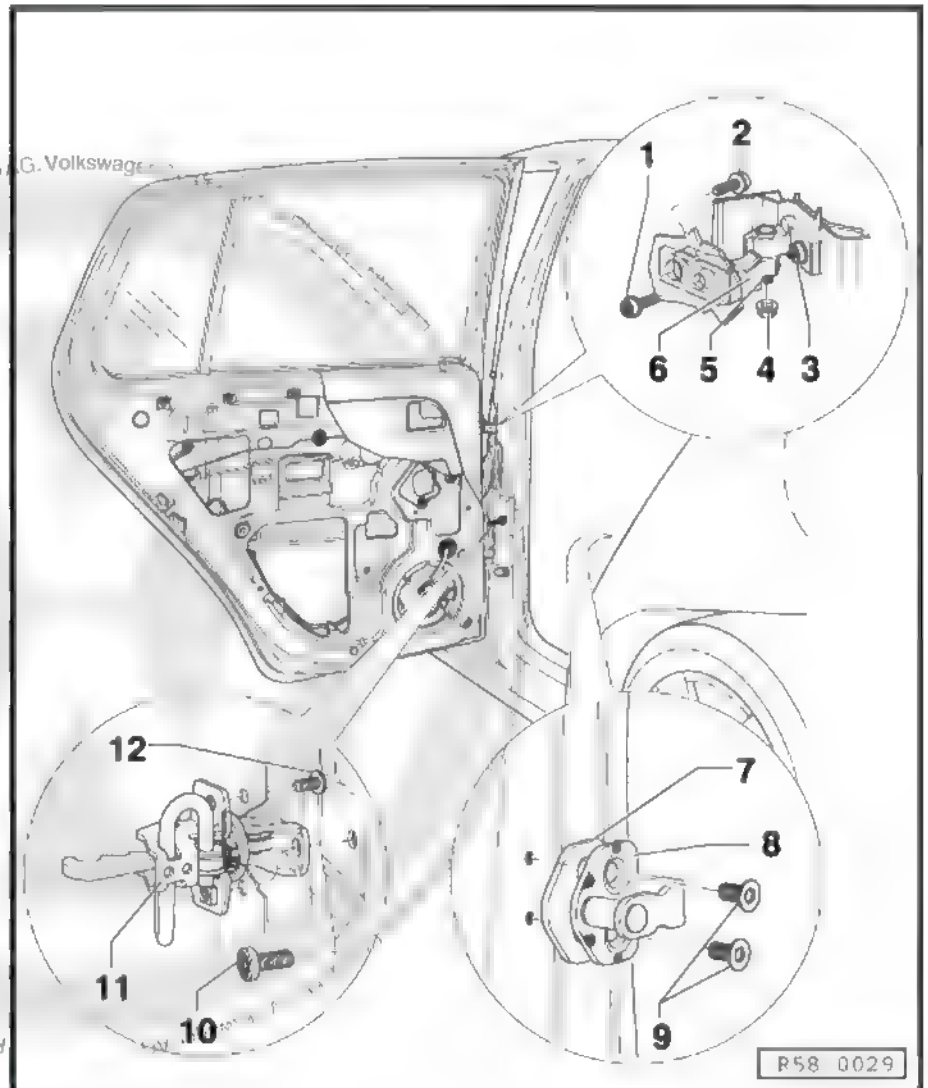
- ☐ Torque: 25 Nm

11 - Door limiter

- ☐ Remove and install ➤ [page 90](#)

12 - Bolt

- ☐ Torque: 6 Nm

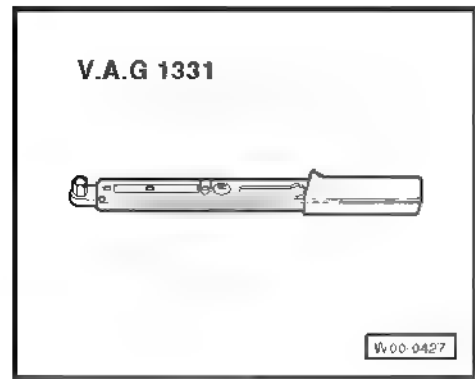


1.2 Rear passenger door - remove and install

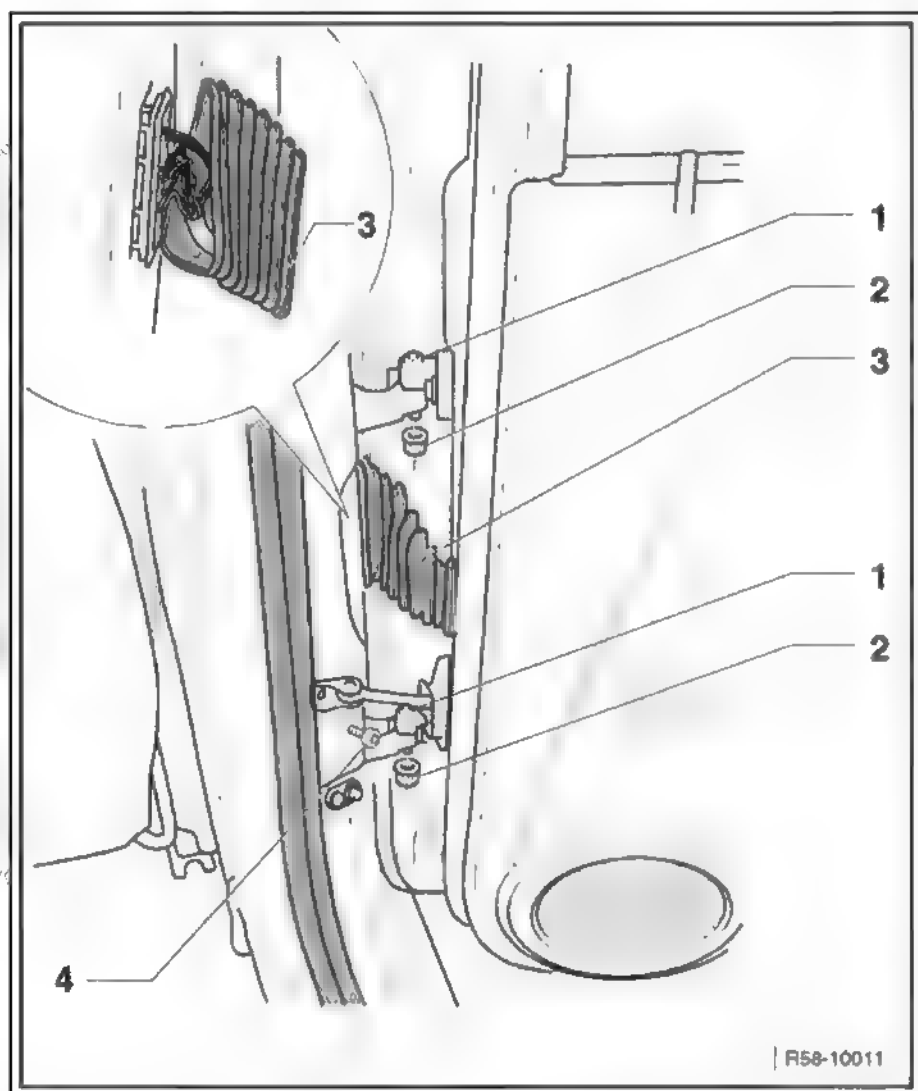
Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



1.2.1 Remove

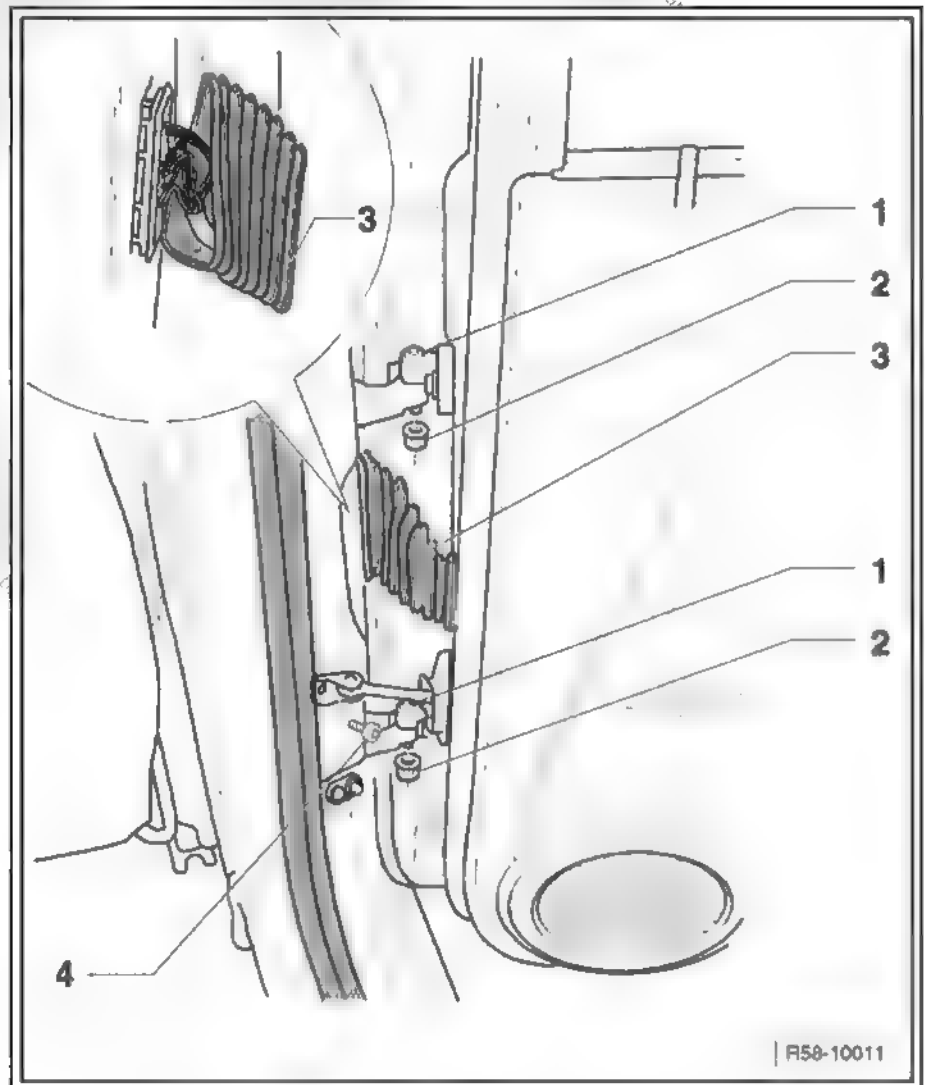


- Pull protection bellows -3- from B-pillar and disconnect electric connections of connector located on B-pillar
- Remove nuts -2- from hinge pins -1-.
- Remove the screw -4- from the door limiter
- Disengage door upward and out of hinge angle bars.



1.2.2 Install

Install is performed in the reverse sequence, observing the following:



- Tighten the nuts -2- of the hinge pins to 14 Nm.
- Tighten the screw -4- of the door limiter to 25 Nm.

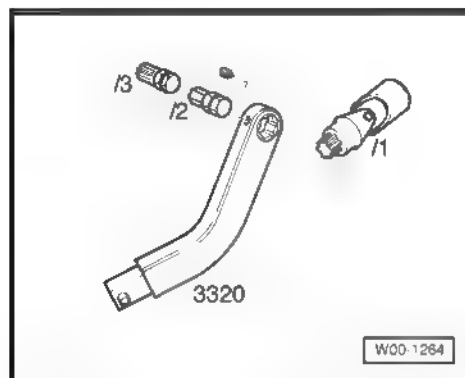
1.3 Rear passenger door - adjust

Special tools and workshop equipment required

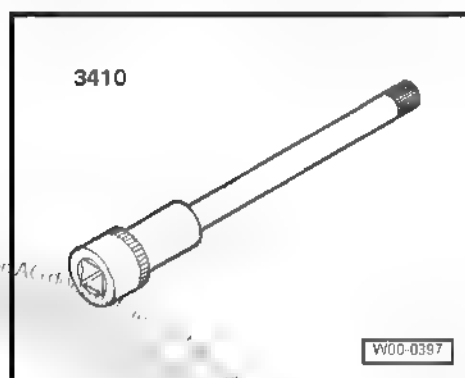
- ◆ Wrench - 3320-



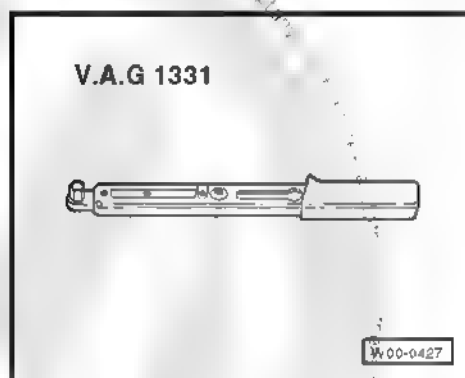
◆ Multi-tooth bits - 3320/3-



◆ Multi-teeth socket - 3410-



◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



Note

- ◆ Vehicle must be supported by its wheels in order to correctly adjust the front door.
- ◆ The front door is correctly adjusted when clearances are as specified ⇒ Body Repairs, Rep. gr. 00; Technical data - Body clearance dimensions when door is locked
- ◆ Take anticorrosion protection measures on hinges and screws after reinstalling or adjusting

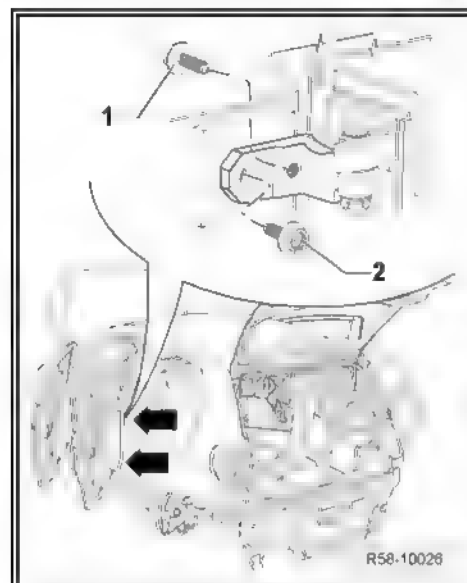


Screws -1- and -2- must be loosen on A-pillar in order to correctly adjust clearances.

- For screw -1- on lower door hinge, lower B-pillar lining must be removed: ⇒ General body repairs, interior, Rep. gr. 70 ; Lining/insulation . Loosen screw with multi-tooth socket - 3410- .
- For screw -1- on upper door hinge, upper B-pillar lining must be removed: ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations Loosen screw with multi-tooth socket - 3410- .

For screw -2- , loosen it with wrench - 3320- and multi-tooth bits - 3320/3- .

Adjust the door arrester ⇒ [page 90](#) .



1.4 Rear passenger door - disassemble and assemble

1.4.1 Disassemble

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the door sealing membrane ⇒ [page 102](#) .
- Remove the door window drive mechanism:
 - manual door window drive ⇒ [page 177](#)
 - power door window drive ⇒ [page 175](#)
- Remove the door window glass ⇒ [page 174](#) .
- Remove the rear door fixed window ⇒ [page 178](#) .
- Remove the internal and external door window glass trims ⇒ [page 178](#) .
- Remove the door window channel ⇒ [page 178](#) .
- Remove the external handle ⇒ [page 94](#) .
- Remove the locking pin rod and the inversion lever.
- Remove the lock ⇒ [page 95](#) .
- Remove the door limiter ⇒ [page 90](#) .
- Disconnect the protection bellows and remove the harness from inside the door.

1.4.2 Assembling

- Assembly is preformed in the reverse sequence to disassembly.

1.5 Rear door - replace

1.5.1 Remove

- Disassemble the door ⇒ [page 89](#) .



- Remove the door ➤ [page 85](#) .

1.5.2 Install

- Apply sealant/caulking to the door ➤ Paint Manual - Body Sealant .
- Install the door noise insulation ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Paint the door ➤ Painting Manual - Repairing paintwork on steel plates and galvanized steel plates.
- Install the door ➤ [page 85](#) .
- Apply anti-corrosive fluid ➤ Paint Manual - Application of anti-corrosive fluid - Anti-corrosive fluid .
- Assemble the door ➤ [page 89](#) .

1.6 Door arrester - adjust

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



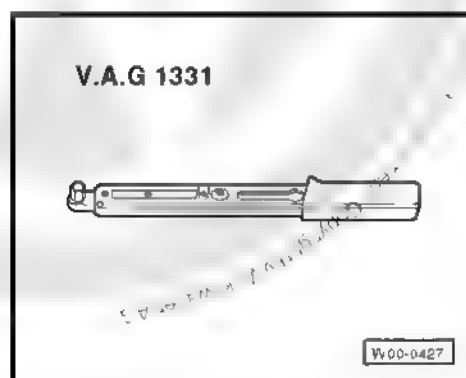
1.6.1 Adjust

- Loosen buffer fastening screws.
- Position and temporarily tighten the door arrester.
- Close the door and check the alignment with the body, based on the clearance dimensions specified ➤ Body - Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- Definitely tighten buffer to:
 - 20 Nm (T45)

1.7 Door limiter - remove and install

Special tools and workshop equipment required

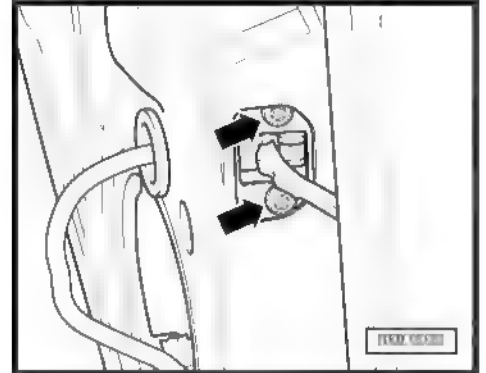
- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





1.7.1 Remove

- Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the door sealing membrane → [page 102](#)
- Remove B-pillar limiter fastening screw (T-40).
- Remove fastening screws -arrows- from door limiter (T-30).
- Remove the limiter from inside the door.



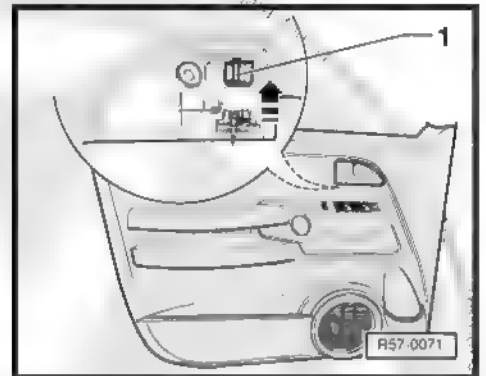
1.7.2 Install

- Installation is performed in the reverse sequence to the removal.

1.8 Internal handle - replace

1.8.1 Remove

- Remove the door lining → General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Disengage lock operating cable.
- Move handle joint pin -1- towards the arrow until hitting buffer on the door lining.
- Activate internal handle, loosen spring and disengage it from the door lining.



1.8.2 Install

- Installation is performed in the reverse sequence to the removal.



1.9 Rear door external handle and lock - assembly overview



WARNING

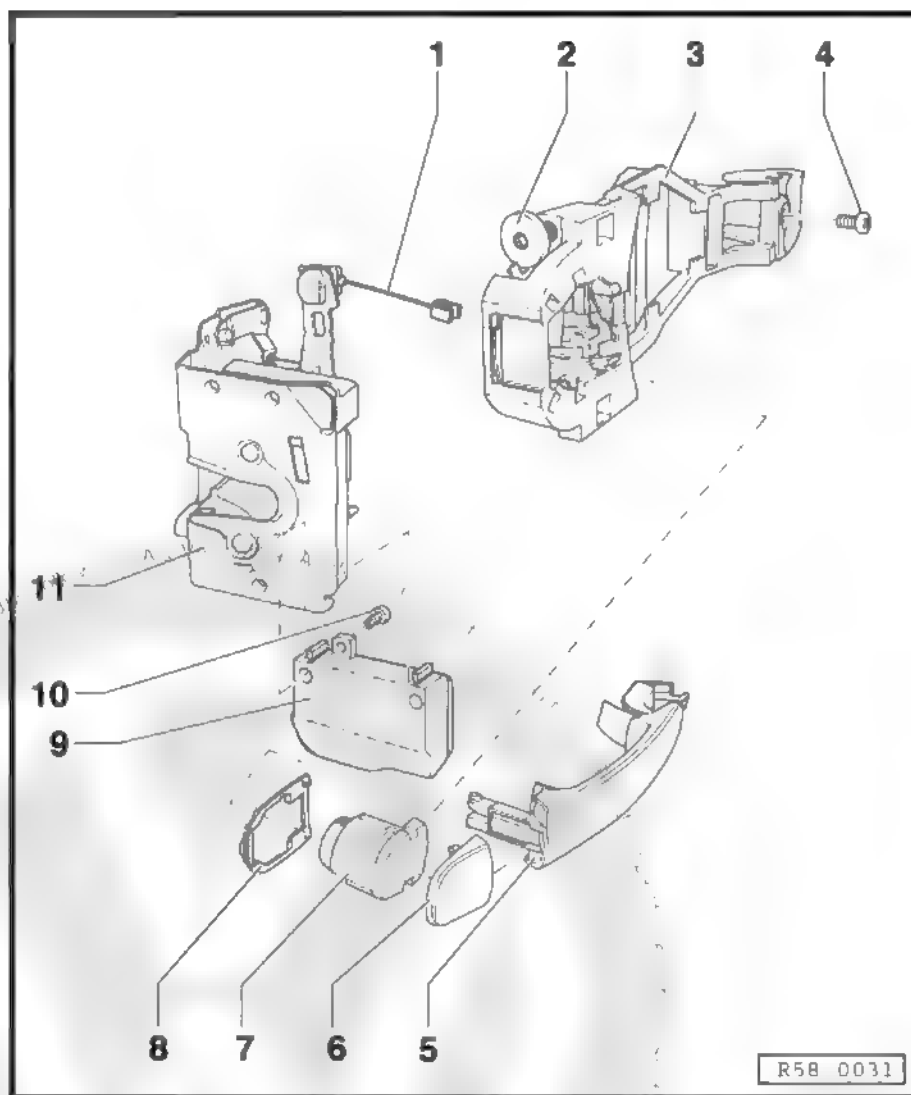
- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"

1 - Operating cable

- ☐ Lock unlocking.

2 - Torx screw

- ☐ Release with the Pin-cers - T10072-
- ☐ When releasing the screw, the fastening of the lock cylinder housing is unlocked -7-, and can be pulled out of the external handle support -3-
- ☐ The screw -2- cannot be tightened without the lock cylinder housing being inserted. The locking ring may fall inside the door.
- ☐ Torque:



-Zamak handle mounting, 4.5 Nm-

- ☐ Torque: -PA6 30 GF handle mounting, 2.5 Nm-

3 - External handle support

- ☐ Remove the lock cylinder case
- ☐ Remove the door handle
- ☐ Remove the door lining ➔ General body repairs, interior; Rep. gr. 70 , Lining / insulation
- ☐ Remove the sealing membrane in the door handle area
- ☐ Release the screw -4-, push the external handle support a little backwards and remove it from the door



4 - Bolt

5 - Door handle

- ☐ Paint according to ➔ Paint Manual - Repairing paintwork in plastic parts .
- ☐ Remove and install ➔ [page 94](#)
- ☐ Cover cap

6 - Cover cap

- ☐ Paint according to ➔ Paint Manual - Repairing paintwork in plastic parts .

7 - Cylinder housing without lock cylinder

- ☐ Remove and install ➔ [page 93](#)

8 - Support

9 - Rear Left/right power latching motor - V307/V308-

- ☐ Replace ➔ [page 101](#)

10 - Bolt

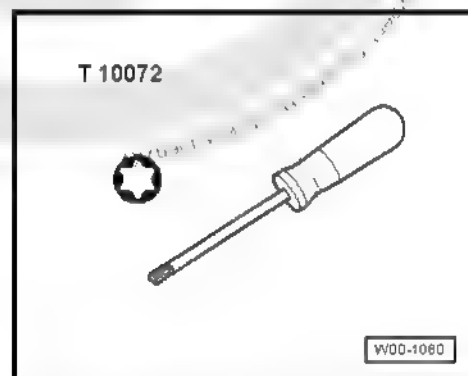
11 - Door lock

- ☐ Remove and install ➔ [page 95](#)
- ☐ Lubricate with low-temperature grease -G 052 745 A3-

1.10 Cylinder housing without lock cylinder - remove and install

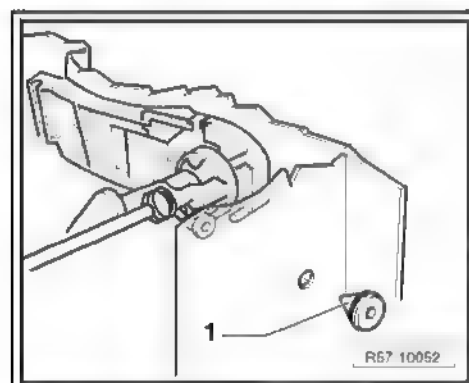
Special tools and workshop equipment required

- ◆ torque wrench - T10072-



Remove

- Disengage plug -1-.





- Pull and hold the door handle -1-. Loosen the screw -3- with the pincers - T10072- and simultaneously press towards the external handle support. This releases the locking in the lock cylinder housing.



Note

If the screw is excessively released, the locking ring may detach from the external handle support and fall into the door as a result.

- Pull the lock cylinder housing -2- out of the external handle support, at a straight angle in relation to the door handle.

Install

Install is performed in the reverse sequence, observing the following:

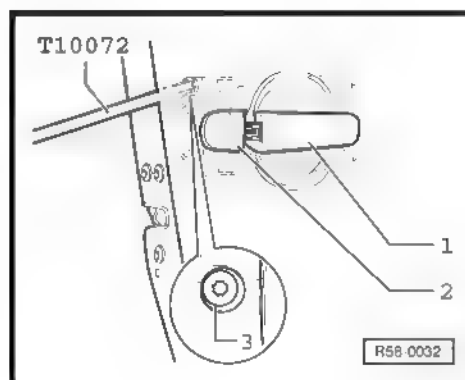
- Place the lock cylinder housing on the external handle support at a straight angle.
- Then, tighten the screw to the external handle support with pincers - T10072-.

The door handle is again fitted to the lock cylinder housing when there is an audible click.



Note

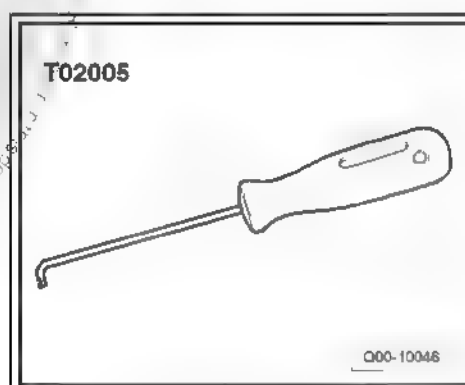
During the assembly, you must press the door handle and the lock cylinder housing against the door plate.



1.11 External door handle - remove and install

Special tools and workshop equipment required

- ◆ Assembly tool - T 10389- or Assembly tool - T 02005-



1.11.1 Remove

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 , Lining / insulation .
- Unglue door sealing membrane from the upper section.

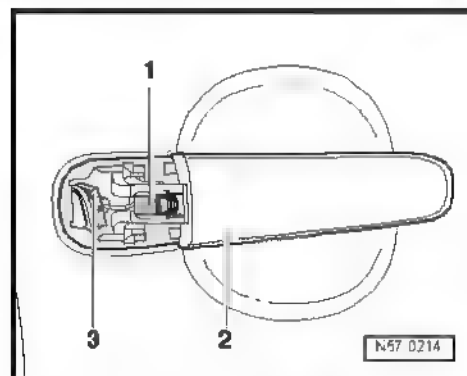


- Remove cylinder housing without lock cylinder.
- Disengage the clip -1- from the door handle -2-.
- Disengage the door handle -2- from the door panel
- Remove the door lock ➔ [page 95](#) .



Note

Door lock removal is necessary in order to reposition lock activation spring



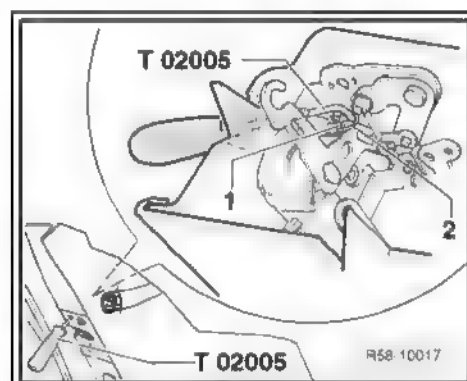
1.11.2 Install



Note

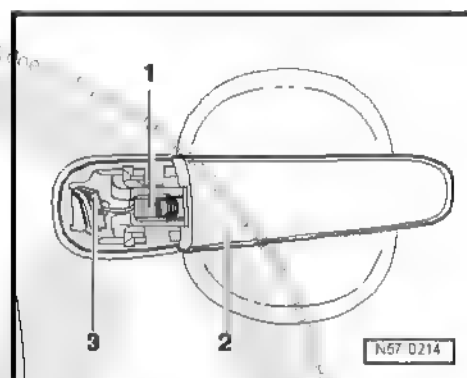
Before installation begins, the spring -2- must be positioned so that the handle has no clearance when activated. To do so, follow instructions below.

- Remove lock fastening screw where tool will be inserted assembly tool - T 10389- or assembly tool - T 02005-
- Introduce assembly tool - T 10389- or assembly tool - T 02005- in lock fastening hole.
- For better vision, light the internal door section with a lamp.
- Fit spring -2- to operating lever -1-.
- Fit the door handle -2- to the door panel.
- Pull the clip -1- inside the plate cut and fit to the door handle.



Note

When assembling the clip, the latch operating lever -3- cannot be pulled and the door handle -2- must be pressed against the door panel.



1.12 External door handle - replace

1.12.1 Remove

- Remove the external handle ➔ [page 94](#) .

1.12.2 Install

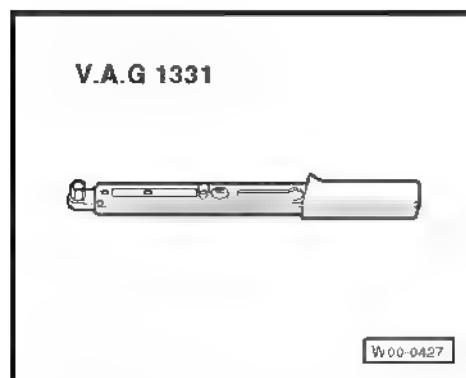
- Paint the handle ➔ Paint manual - Repairing paintwork in plastic parts .
- Installation is performed in the reverse sequence to the removal.

1.13 Rear door lock - remove and install

Special tools and workshop equipment required

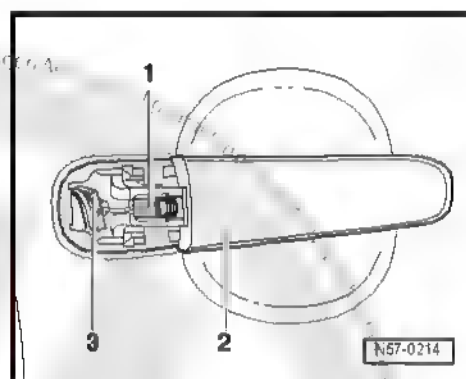


- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

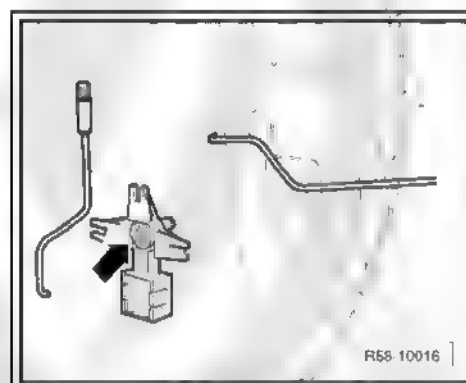


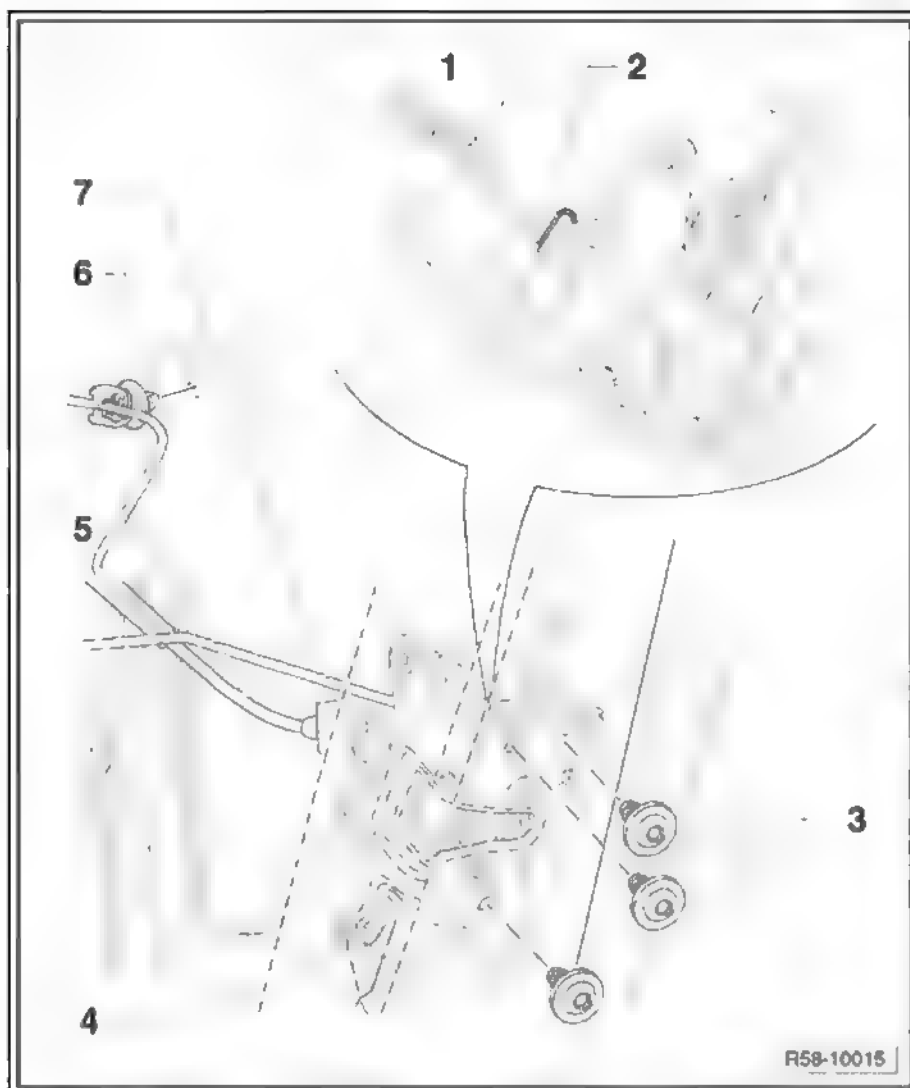
1.13.1 Remove

- With the door window closed, remove the rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Detach door sealing membrane from the upper section.
- Remove the external handle housing ⇒ [page 93](#) .



- Disengage the clip -1- from the door handle -2-.
- Push pin -arrow- and remove the inversion lever.

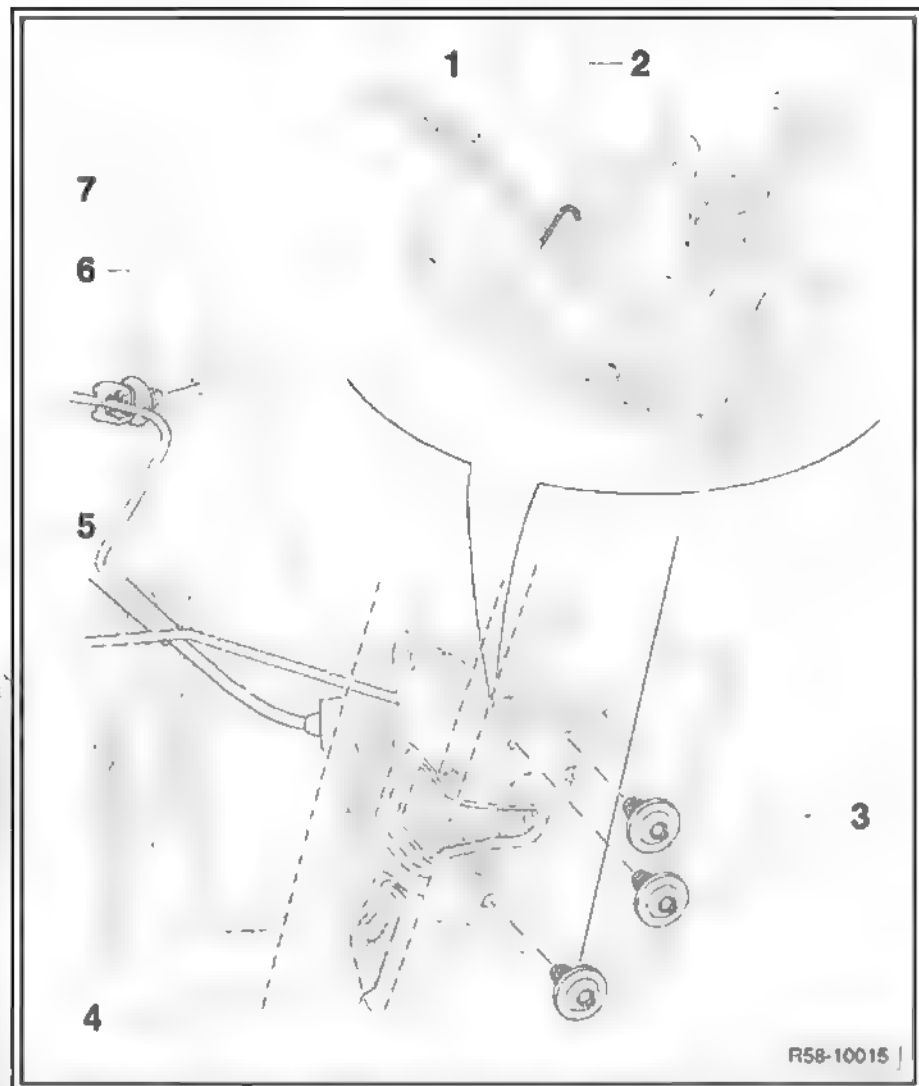




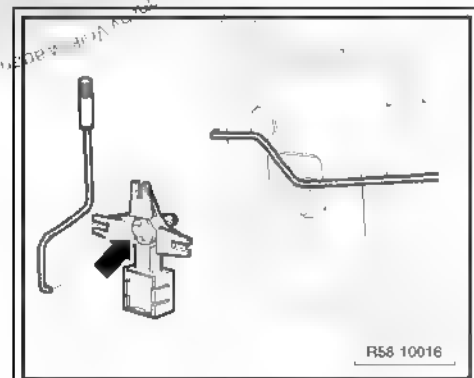
- Disengage from command rod -7- clip -6-.
- Disengage connector -4- from left/right rear central locking system motor - V307/V308-.
- Remove the fastening screws -3- from the door lock and remove the lock through the assembly opening.



1.13.2 Install



- Fit spring -1- to lock operating lever -2-.
- Position the lock and install the fastening screws -3- of the door lock to a final torque of 4 Nm.
- Connect connector of left/right rear central locking system motor - V307/V308- -4-.
- Fit to lock command rod -7- clip -6-.





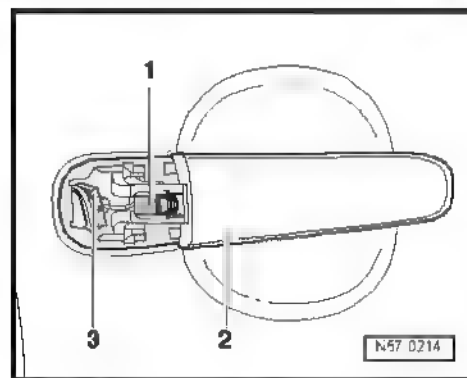
- Push the pin -arrow- and install the inversion lever.
- Pull the clip -1- inside the plate cut and fit to the door handle -2-.



Note

When assembling the clip, the lock operating lever -3- cannot be pulled and the door handle -2- must be pressed against the door plate

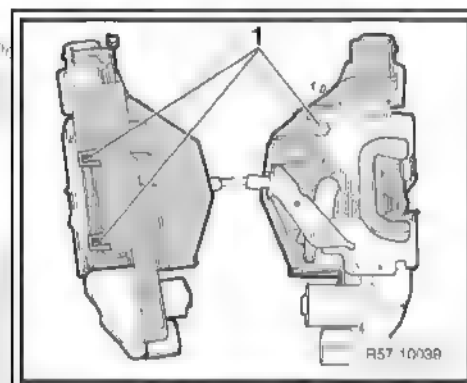
- Install the lock cylinder housing ⇒ [page 93](#) .
- Install the door sealing membrane, pressing it with the pressure roll - 3356- .
- Install the rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation



1.14 Rear door lock - replace

1.14.1 Remove

- Remove the lock ⇒ [page 95](#) .
- Disengage locks -1- and separate the lock cover cap.
- Remove lock operating cable ⇒ [page 100](#) .
- Remove the operating cable from the internal handle ⇒ [page 100](#) .
- Remove bushings.
- Remove left/right central locking system motor - V307/V308- ⇒ [page 101](#) , if any.



1.14.2 Install

- Installation is performed in the reverse sequence to the removal.

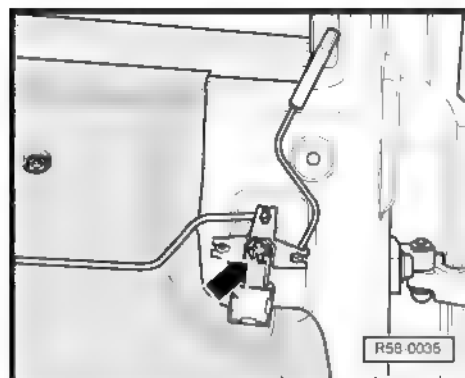
1.15 Inversion lever - replace

1.15.1 Remove

- Remove rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Disengage command rod from inversion lever.
- Remove lock locking pin rod.



- Remove pin -arrow- of inversion lever -1-.
- Remove inversion lever.



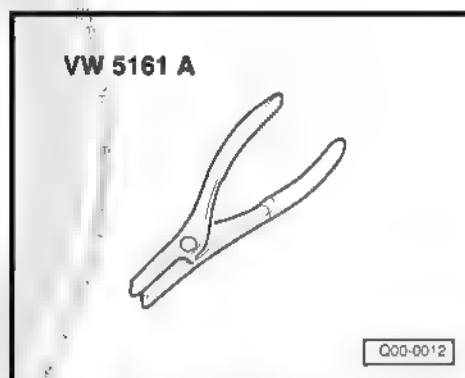
1.15.2 Install

- Installation is performed in the reverse sequence to the removal.

1.16 Lock operating cable - remove and install

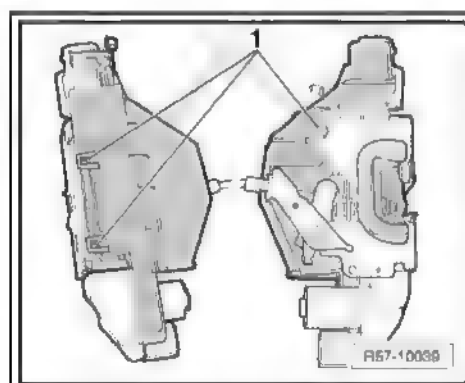
Special tools and workshop equipment required

- ♦ Pliers - VW 5161A-



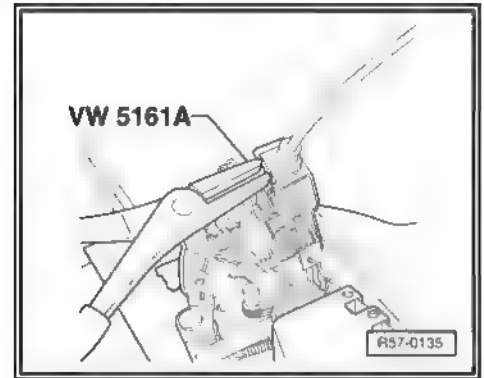
1.16.1 Remove

- Remove the door lock ⇒ [page 95](#) .
- Disengage locks -1- and separate the lock cover cap.
- Disengage bushing cable end:



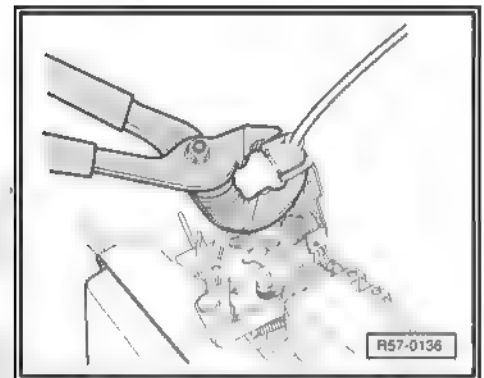


- Slightly open cable fitting support with the pliers - VW 5161A-tool.
- Disengage the cable and remove it.



1.16.2 Install

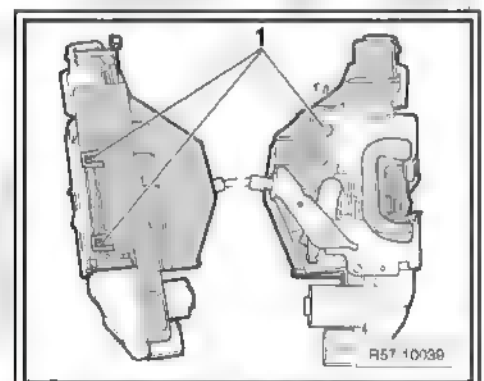
- Fit cable to lock fitting support.
- Fit cable end to bushing.
- Slightly tighten cable fitting support with pliers.
- Install door lock ⇒ [page 95](#) .



1.17 Rear left/right power latching motor - V307/V308- - replace

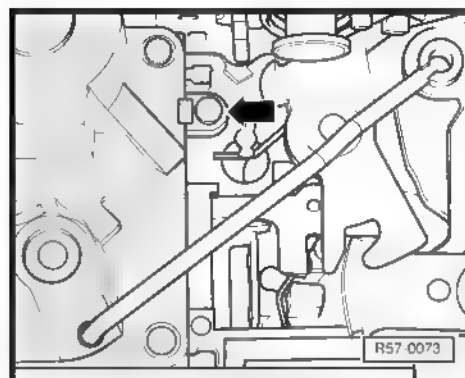
1.17.1 Remove

- Remove the door lock ⇒ [page 95](#) .





- Disengage locks -1- and separate the lock cover cap
- Remove screw -arrow- that fastens the motor
- Disengage and remove the motor operating rod.



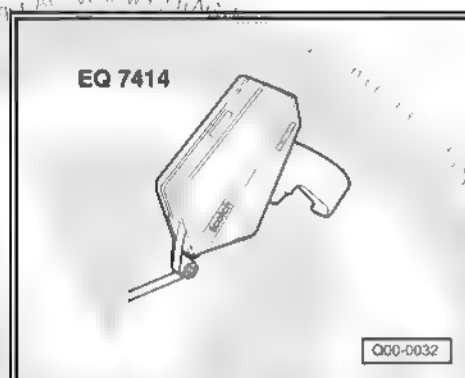
1.17.2 Install

- Installation is performed in the reverse sequence to the removal.

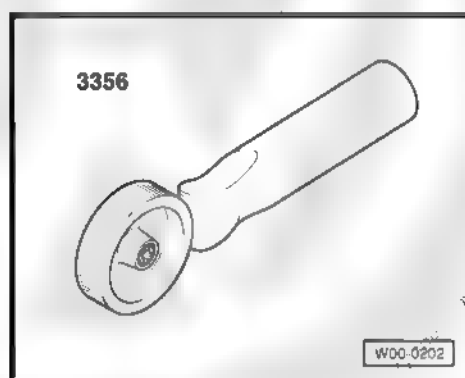
1.18 Door sealing membrane - remove and install

Special tools and workshop equipment required

- ◆ Transferable adhesive tape applicator - EQ 7414-



- ◆ Pressure roll - 3356-



1.18.1 Remove



WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"



- Remove the door lining ► General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install
- Remove the adhesive tapes that fasten the membrane to the lock operating cable and wiring harnesses
- Remove bushings -1- with the ejector lever - 80-200- .
- Detach the sealing membrane and remove it



Note

Write down on the membrane the number of times it has been removed, 1st, 2nd or 3rd time

- Remove any remaining adhesive from the internal door panel using the cleaning solution - D 009 401 04- .



Note

Moisten a cloth with the cleaning solution - D 009 401 04- and gently apply it over the affected area. Allow the product to work for a moment and then rub towards the centre starting from the edges. Repeat the operation if necessary. Next, rub the surface with a cloth until it is completely dry.

1.18.2 Install



WARNING

- ◆ *When handling chemicals follow the safety instructions ► Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ► Electronic Parts Catalogue "ETKA"*



Note

- ◆ *Polypropylene film with thickness of $0,2 \pm 0,02$ mm. Adhesion strength ≥ 4 N/cm.*
- ◆ *The membrane has an sensitive acrylate-based adhesive coating that ensures it can be removed up to 3 times without affecting the adhesive performance. If the layer of adhesive is damaged, i.e., at 4th removal, install the membrane by using the transferable adhesive tape as described below.*
- ◆ *The membrane may be reinstalled if there is no damage such as stretching or wrinkles which can fatally compromise the seal against water and dust*
- ◆ *Apply transferable adhesive tape to the internal door panel (membrane adhesion area) with the transferable adhesive tape applicator - EQ 7414- , in case of loss of membrane adherence.*
- Install the membrane by passing the cable and harnesses through the holes and paste it to the internal door panel
- Press the door sealing membrane with the pressure roll - 3356-



- Fasten the sealing membrane to the lock operating cable and wiring harnesses.



Note

Self-adhesion felts are placed under the membrane to eliminate vibration and noise from the membrane due to the flow of air. Replace them when replacing the membrane.

- Install the door lining ➤ General body repairs, interior, Rep. gr. 70 ; Lining / insulation - Door linings - remove and install

1.19 Door sealing packings - assembly overview

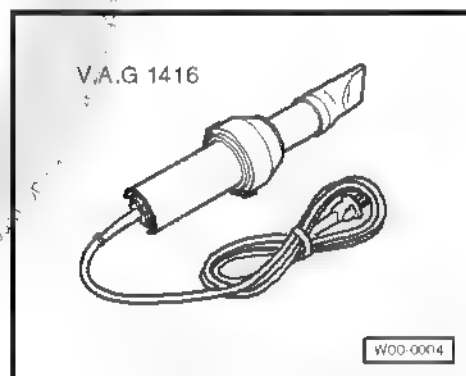


WARNING

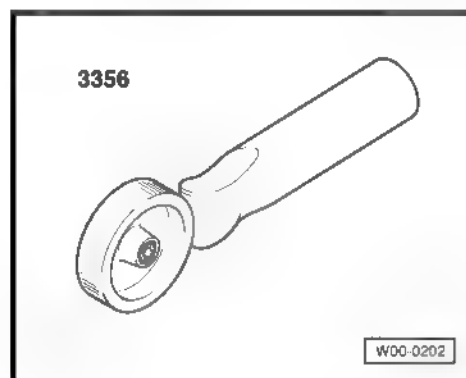
- ◆ *When handling chemicals follow the safety instructions ➤ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➤ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-

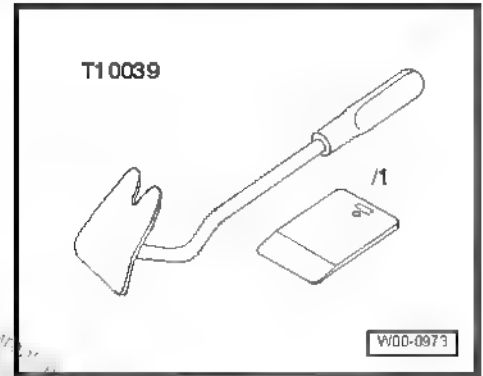


- ◆ Pressure roll - 3356-





◆ Wedge - T 10039/1-



1 - Pin

- ☐ under pressure ▶ 02.05
- ☐ threaded 03.05 ▶
- ☐ non-existent as of chassis C4103617

2 - External door trim

- ☐ self-adhesive
- ☐ Remove and install
⇒ [page 106](#)

3 - Internal lid trim

- ☐ covered on lower section by threshold trim
- ☐ Remove and install
⇒ [page 107](#)

4 - Clip

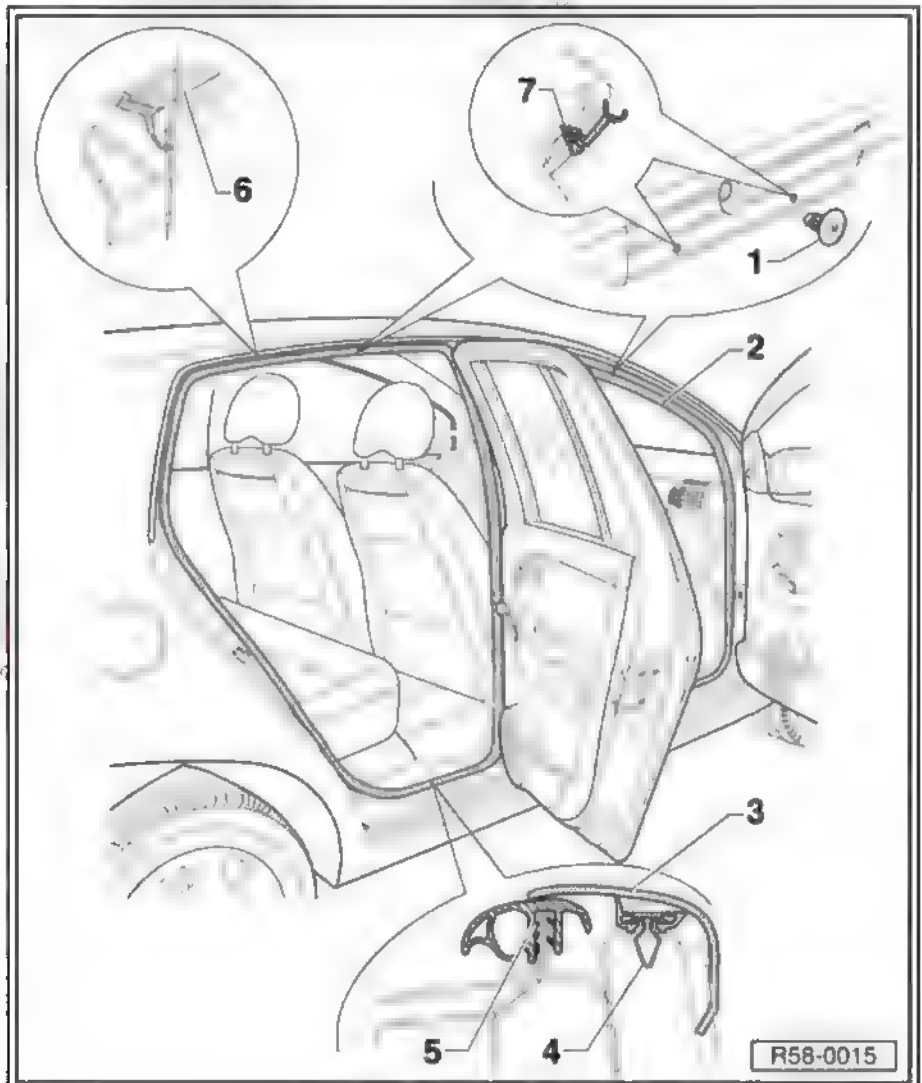
5 - Threshold trim

- ☐ remove and install
General body repairs
interior; Rep. gr. 68 ; Internal equipment

6 - Double-sided tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.
- ☐ when assembling a new external packing, remove double-sided tape liner.

7 - Door external packing fitting (rack area)





1.20 External door packing - remove and install



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"

Remove

- Remove fastening pins with ejector lever - 80-200-



Note

- ◆ For vehicles produced as of chassis C4103617, the rubber tab fastened by fastening pin -1- no longer exists.
- ◆ Removable with ejector lever - 80-200- only for vehicles manufactured until 02 05. Pin for vehicles manufactured from 03.05 is threaded.

- Heat up trim with the hot air blower - VAG 1416- .
- Detach trim using wedge - T 10039/1- .

Install

- Clean door frame in the adhesion area with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04- . Dry area with a dry cloth.
- Heat up the trim adhesive tape and door frame in the assembly section with the hot air blower - VAG 1416- at a temperature of 30 - 40 °C.
- Press packing -7- fitting (above front door and above rear door) against holes in the door frame.
- Remove double-sided tape liner -6-, glue trim and centralize it in the area of the C-pillar. Firmly press packing (above 10 N) with a pressure roll - 3356- . Only move the pressure roll in one direction.



Note

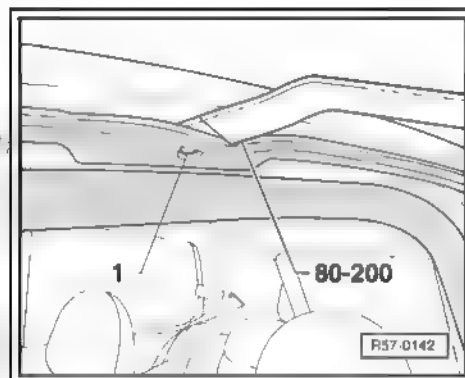
Do not move it back and forth.

- Install pins -1-.



Note

- ◆ For vehicles produced as of chassis C4103637, the rubber tab fastened by fastening pin -1- no longer exists
- ◆ After assemble, the door must be kept open for a minimum period of 30 minutes so that the door's pressure on packing do not lead to premature packing detaching





1.21 Internal door trim - remove and install

Remove

- Remove front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Internal Equipment .
- Disengage and remove the trim.

Install



Note

- ◆ *The vulcanized splice of the packing shall be mounted at the same height of the lock operating lever in the bonnet -arrow A-.*
- ◆ *For partially removed trim, it is necessary to press the trim sides -arrow- before assembly.*



- Manually engage the trim, initially in the door crest, and engage the remaining trim spots distributing trim tension.
- Slightly press the trim with a rubber hammer.



- Install front door threshold trim ➤ General body repairs, interior; Rep. gr 68 ; Internal Equipment .





60 – Sunroof

1 Sliding / tilting sunroof (Fox)

1.1 Operation

The sliding / tilting sunroof is opened and closed by the sunroof sliding adjuster - E139- , with the ignition switched on

It is possible to open or close the sliding / tilting sunroof with ignition off if driver's or passenger's door is not open.

There are marks in the sunroof sliding adjuster which correspond to the established opening positions. Glass lid opening positions. However, it is possible to open the roof in any wanted intermediary position for sliding or tilting of the sunroof, by turning the command in the corresponding direction.

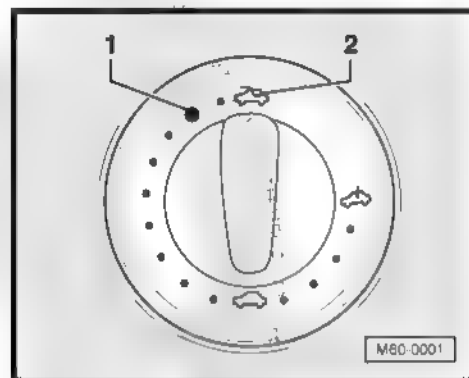
Sliding/tilting sunroof opening with the control in position -1-, in the so-called convenience position, significantly reduces wind noises with total opening, control position -2-.

Sliding/tilting sunroof is equipped with closing strength limiter in the sliding region. If there is any obstacle during closing operation, roof will automatically reopen.

Additionally, there is an emergency closing function. Upon problems with closing, sliding roof may be firmly closed by pressing the command, which shall be in the "closed sunroof" position

Closing strength limiting feature is off upon emergency closing feature.

The Sliding sunroof motor - V1- is protected from excessive heating by an operation length limitation. The protective mechanism works after uninterrupted activation for approximately two minutes. It may only be activated again after a cooling period.



1.2 Sliding/tilting sunroof with glass lid - Assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions. Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Glass lid for sliding/tilting sunroof (safety toughened glass)

- ☐ Remove glass lid for sliding/tilting sunroof. ➔ [page 111](#)
- ☐ Install glass lid for sliding/tilting sunroof ➔ [page 111](#).
- ☐ Adjust glass lid for sliding/tilting sunroof ➔ [page 112](#).

2 - Cover trim

- ☐ Packing joint centralized in rear region.
- ☐ Roof packing replacement ➔ [page 113](#)

3 - Sunroof lining

- ☐ Remove and install sun protector ➔ [page 114](#).

4 - Sliding

5 - Folding frame

6 - Water chute

- ☐ remove, remove guide with steel cable

7 - Bolt

8 - Tip

- ☐ use adhesive Butyl cord for sealing -AKL 450 005 05-

9 - Guide frame

- ☐ Lubricate guide channels with special grease - G 000 450 02- if necessary, otherwise, operation is not ensured.

10 - Sliding sunroof motor - V1-

- ☐ Remove ➔ [page 116](#)
- ☐ Adjust activation (zero position) ➔ [page 117](#)

11 - Bolt

- ☐ Torque: 3.5 Nm
- ☐ must always be replaced

12 - Sliding sunroof adjustment control unit - J245

- ☐ Remove ➔ [page 115](#)
- ☐ Selector command is fitted in command unit
- ☐ Remove selector key ➔ [page 116](#)

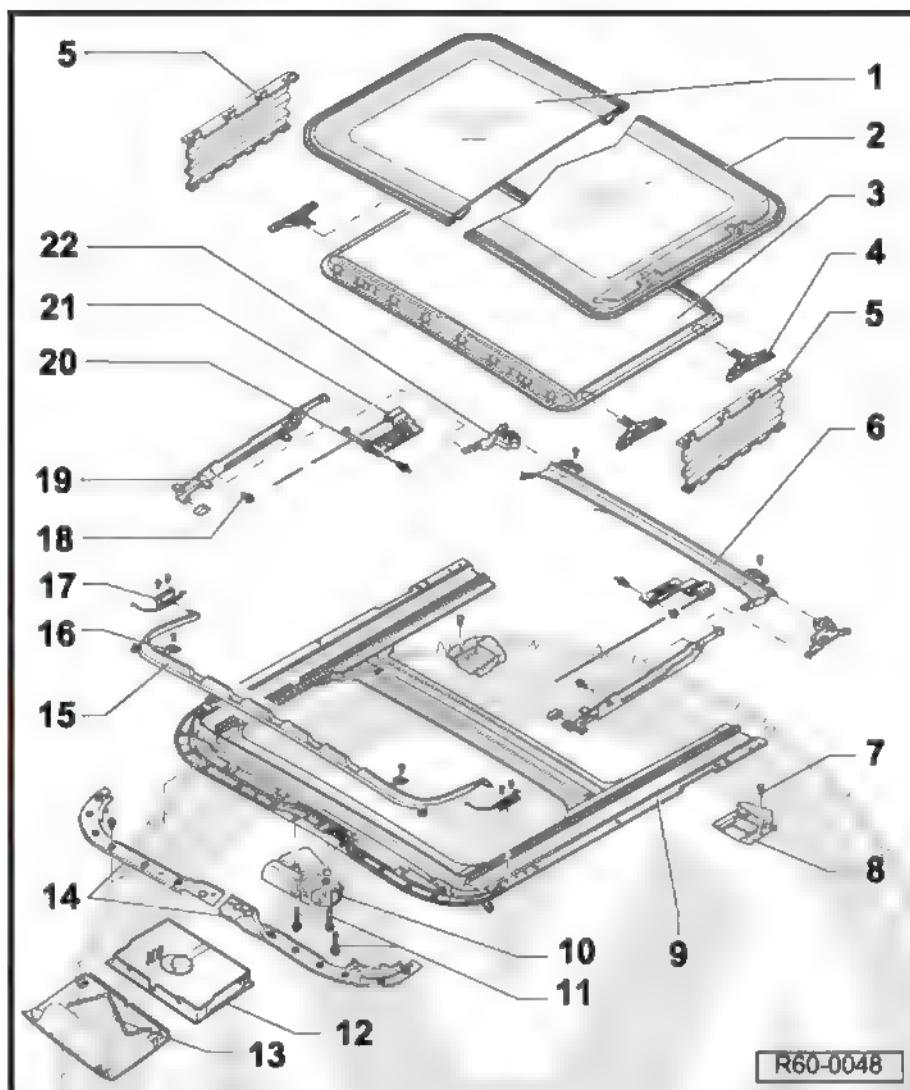
13 - Hexagonal wrench for manual operation

- ☐ fitted to the electric mechanism lid

14 - Cable cap

15 - Wind deflector

- ☐ Remove ➔ [page 114](#)

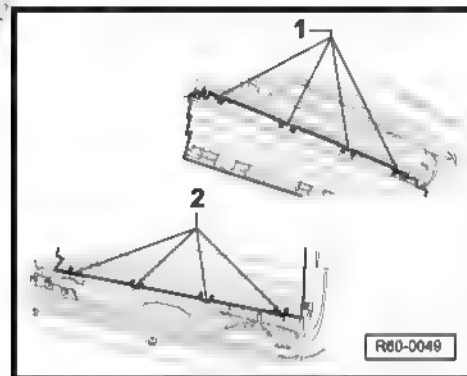




- 16 - Hinge
- 17 - Deflector activation spring
- 18 - 25-pin connector -T25-
☐ Torque: 4.5 Nm
- 19 - Sliding guide
☐ Remove ➔ [page 118](#)
- 20 - Sliding pin
- 21 - Guide with steel cable
☐ Remove ➔ [page 118](#)
- 22 - Chute positioner

1.3 Sliding/tilting sunroof glass lid - remove

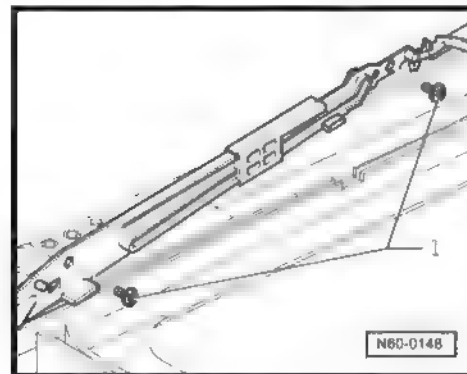
- ✚ Push sunroof lining backwards
- ✚ Tilt sunroof lid.
- Disengage locks -1- from folding frame of the glass lid metal structure and disengage locks -2- from the sunroof guide frame.



- Remove fastening screws -1- (Torx -T25- ; 4.5 Nm) .
- Remove sliding/tilting sunroof lid from above.

Note

The sliding/tilting sunroof must not be put in "open" position when glass lid is removed, as the water chute would not be compressed by the glass lid and might stick to the roof.



1.4 Glass lid for sliding/tilting sunroof - install

Note

Lid must be installed in position "0"

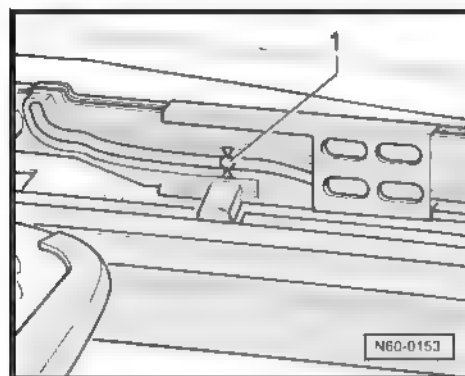


Position "0"

- Guide slide pin -1- must be aligned with the marks in the guide slide

If it is not, adjust them.

- Place sliding/tilting sunroof lid on top and screw fastening screws (sliding device/lid) on guide sliding device.

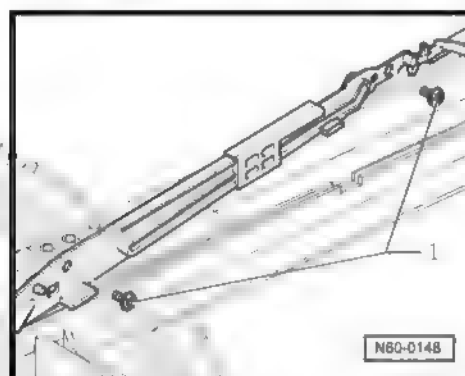


- Moderately tighten fastening screws -1- (Torx -T25-).

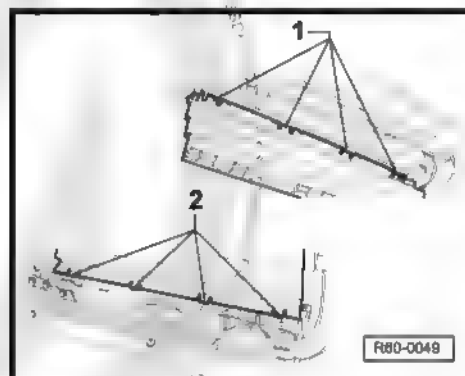


Note

*Tighten the fastening bolts after lid height adjustment => page
=> [page 112](#) (4.5 Nm).*



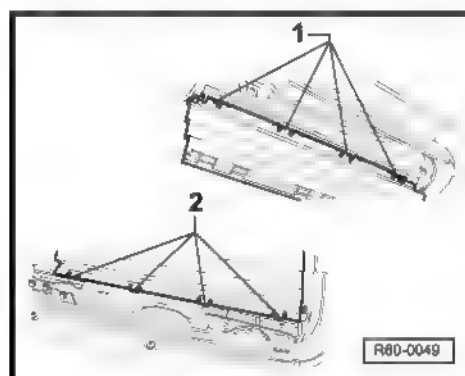
- Fit the locks -1- of the folding frame of the glass lid metal structure, and release the locks -2- from the sunroof guide frame.
- Turn the sunroof lid into closed position.
- Push sunroof lining forward.



1.5 Glass lid for sliding/tilting sunroof (height adjustment) - adjust

Sliding/tilting sunroof zero position in order

- Push sunroof lining backwards
- Tilt sunroof lid.
- Disengage locks -1- from folding frame of the glass lid metal structure and disengage locks -2- from the sunroof guide frame.





- Loosen fastening -1- screws (Torx -T25- ; 4.5 Nm) .
- Move glass lid into position "open"
- Move glass lid into position "closed"
- Adjust glass lid height in the front and rear for both sides, as follows:

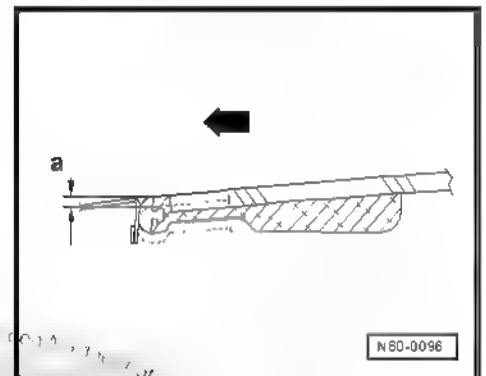
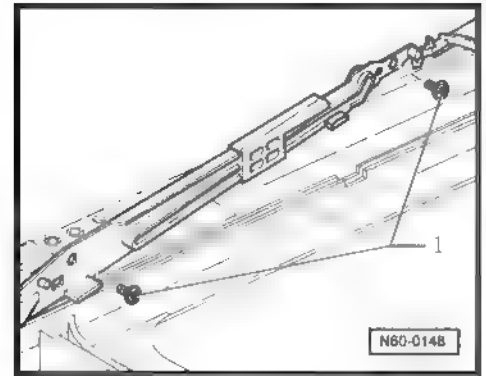
Lid adjustment in front section:

a = 0 to 1 mm below roof level

Arrow = indicating vehicle front

Lid adjustment, rear section:

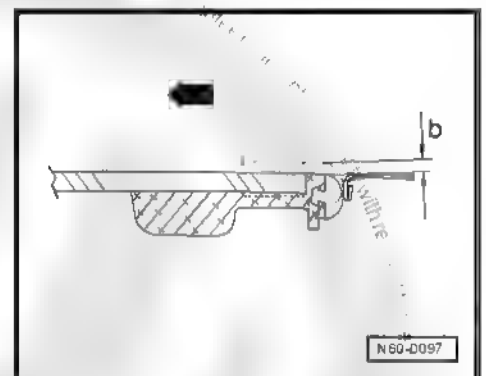
a = 0 to 1 mm above roof level



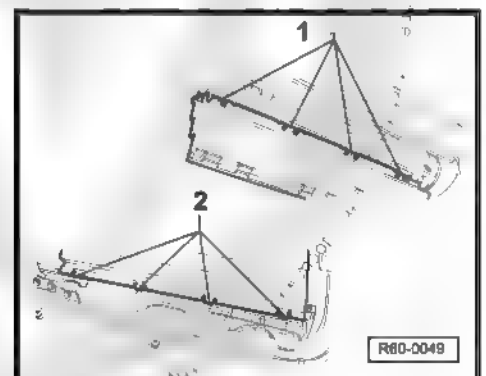
Arrow = indicating vehicle front

- Tighten glass lid screws (4.5 Nm).

Always symmetrically adjust right and left sides of the glass lid.



- Fit the locks -1- of the folding frame of the glass lid metal structure, and release the locks -2- from the sunroof guide frame.
- Turn the sunroof lid into closed position.
- Push sunroof lining forward.

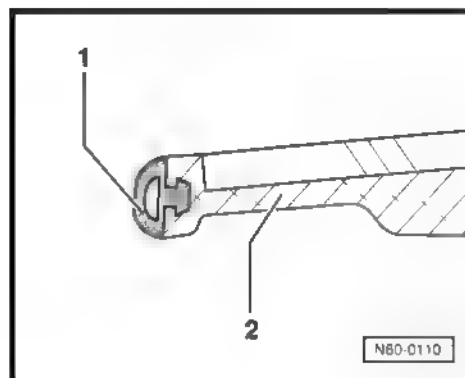


1.6 Lid trim - replace

- Remove the glass lid of the sliding/tilting sunroof
- Disengage packing -1-.

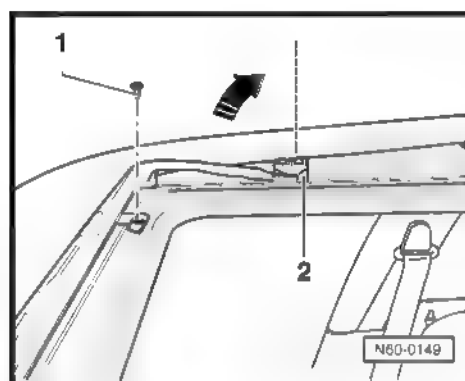


- Press new packing onto lid metal structure -2-.



1.7 Air deflector - remove

- Open sliding/tilting sunroof completely
- Remove the bolt -1-.
- Move deflector vertically in the direction indicated by the -arrow- and disengage it from the rail -2-.



1.8 Sunroof lining - remove and install



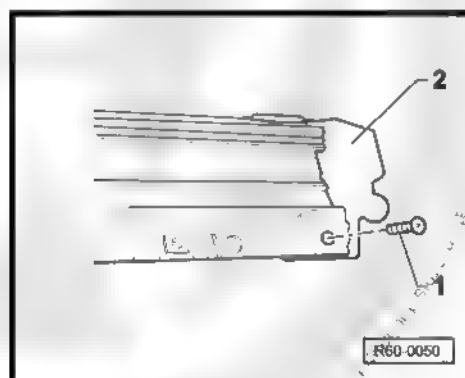
WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 60
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Remove

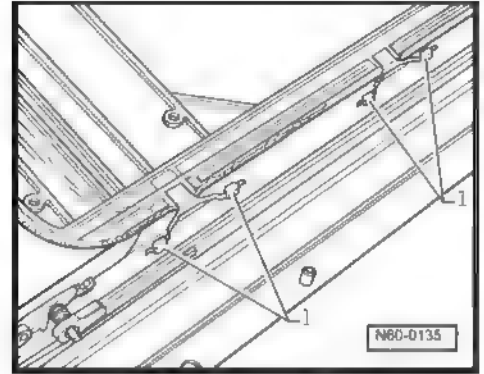
- Remove sunroof
- Remove screw -1- and disengage tip -2-.
- Pull roof lining backwards and disengage from frame.

Install





- Put roof lining, fitting roof lining slider -1- (sliders are fastened to roof lining) to frame guides

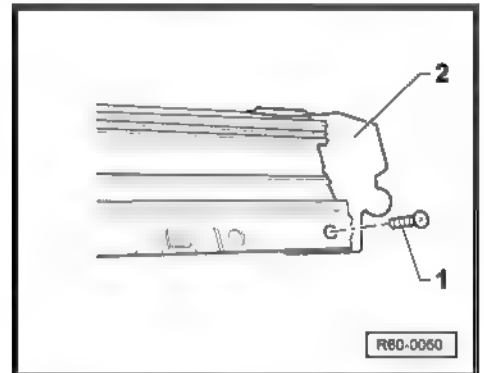


- Install screw -1- and fit tip -2-.



Note

Seal tip -2- with a Butyl adhesive bead - AKL 450 005 05- .

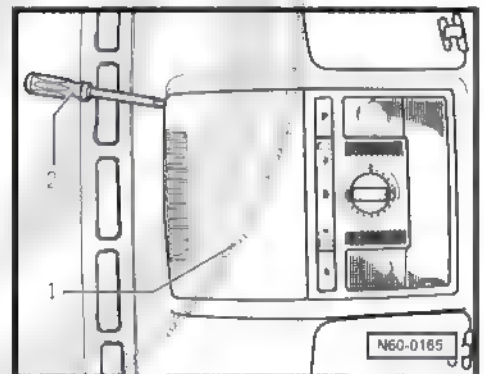


1.9 Sliding sunroof movement control unit - J245- - remove



Note

- ◆ Pay attention to coding instructions in the radio user manual before disconnecting the battery.
- ◆ Pay attention if vehicle accessories (radio, clock, power window) are checked according to repair manual and/or operation instruction after disconnecting the battery.
- Disconnect the battery ground strap.
- Disconnect the cover -1- from the driver with a screwdriver -2-.
- Disconnect connectors of Ultra-sound sensor for alarm system - G209- , if any.



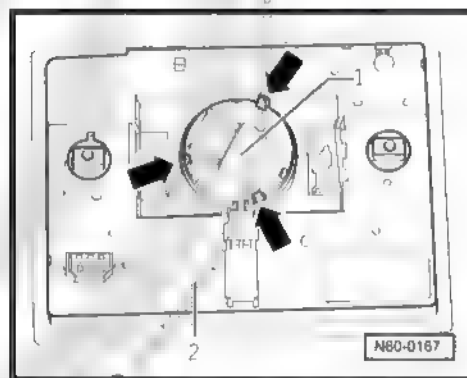


- Disconnect sliding sunroof movement control unit - J245- -1- (with selector key and internal light) and disengage from shaped roof from below and front -arrow-.
- Remove fitting connections



1.10 Sliding/tilting sunroof selector key - remove

- Remove the Sliding sunroof adjustment control unit - J245- .
- Unlock locking tabs -arrows- on the rear of the control unit and remove selector key -1- from command unit -2-.



1.11 Sliding sunroof activation motor - V1- - remove

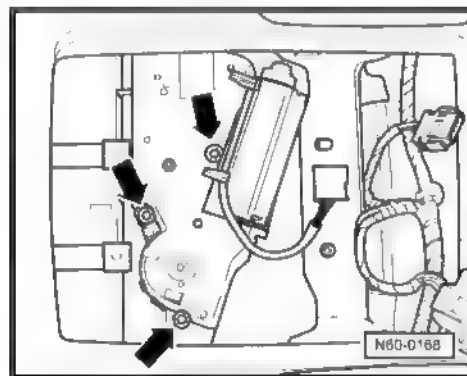


Note

Only remove and install sliding/tilting sunroof activation motor with roof closed (zero position)

- Remove the Sliding sunroof adjustment control unit - J245- ⇒ [page 115](#) .
- Remove **screws** -arrows- and remove sliding/tilting roof activation.
- Disconnect connections and cables

Activation motor screws are micro-armored and must always be replaced (3.5 Nm)





1.12 Sliding sunroof motor - V1- (zero position) - adjust

Adjustment of position zero may be necessary when activation engine is replaced, not removed in position zero; or when sliding/tilting roof is closed or opened by manual operation

After removing the activation engine, connect the engine connectors and follow the steps below

- With selector key, select "Fully opened roof".
- With selector key, select "Fully closed roof".
- With selector key, select "Fully opened tilting roof".
- With selector key, select "Fully closed tilting roof".

After the executing the sequence above, install the roof activation engine in the closed position (zero position).

1.13 Parallelism - check

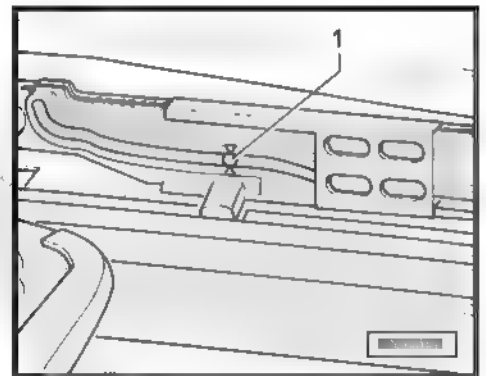
- Remove folding frames from sliding/tilting roof.



Note

The glass lid must be in zero position (lid closed)

The sliding pin -1- must be aligned with the markings in the slide guide.



1.14 Parallelism - adjust



Note

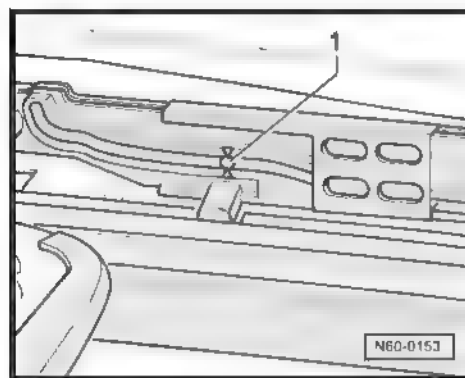
Parallelism adjustment can only be carried out with electric activation engine and glass lid removed (in zero position).

- Remove sliding/tilting roof activation motor.



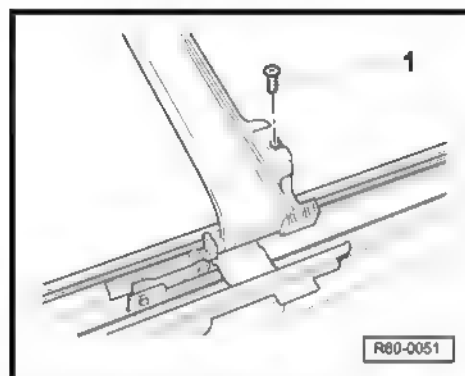
Zero position:

- Place sliding pin -1- aligned with marks in sliding device guide.
- Install roof activation motor (zero position) to this position.

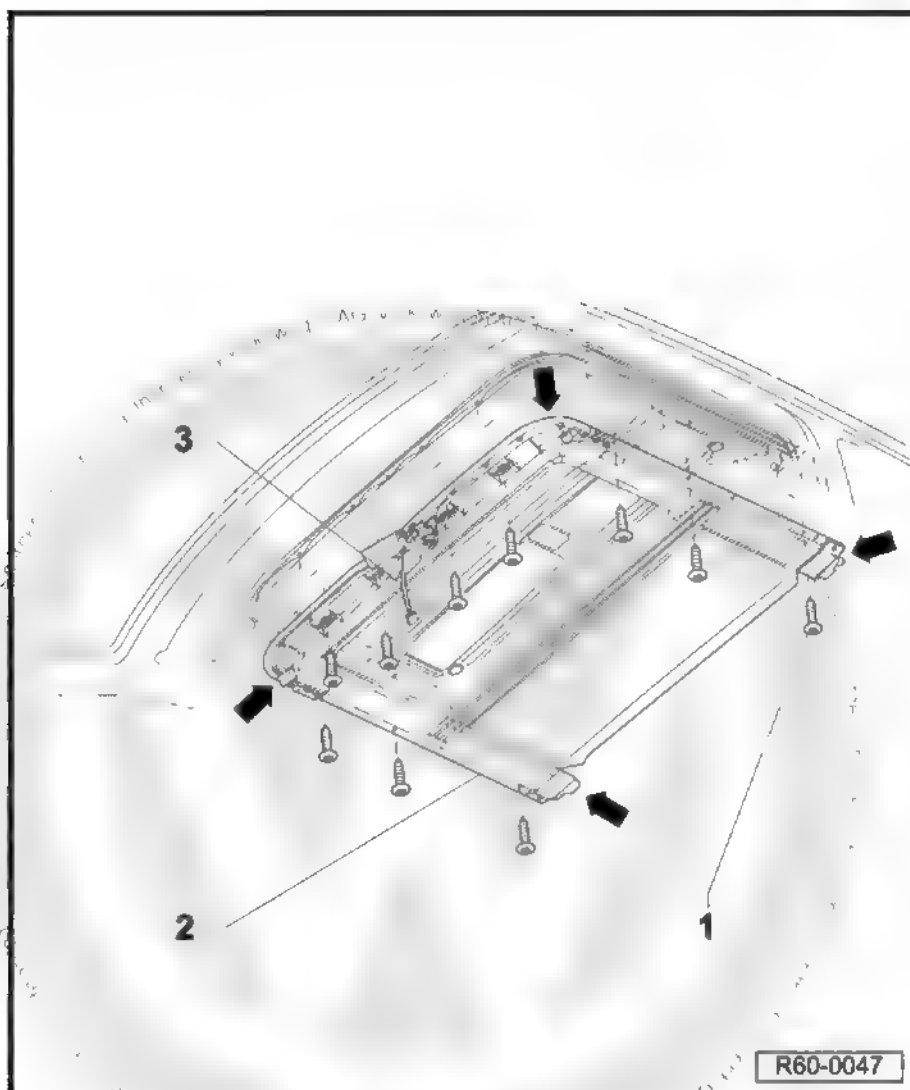


1.15 Sliding guide - remove

- Remove sliding/tilting sunroof glass lid.
- Remove sunroof ⇒ [page 118](#) .
- Remove the air deflector.
- Remove the fastening -1-screw of the gutter in the positioner.
- Disengage sliding device guide from guide frame.



1.16 Sunroof - remove and install

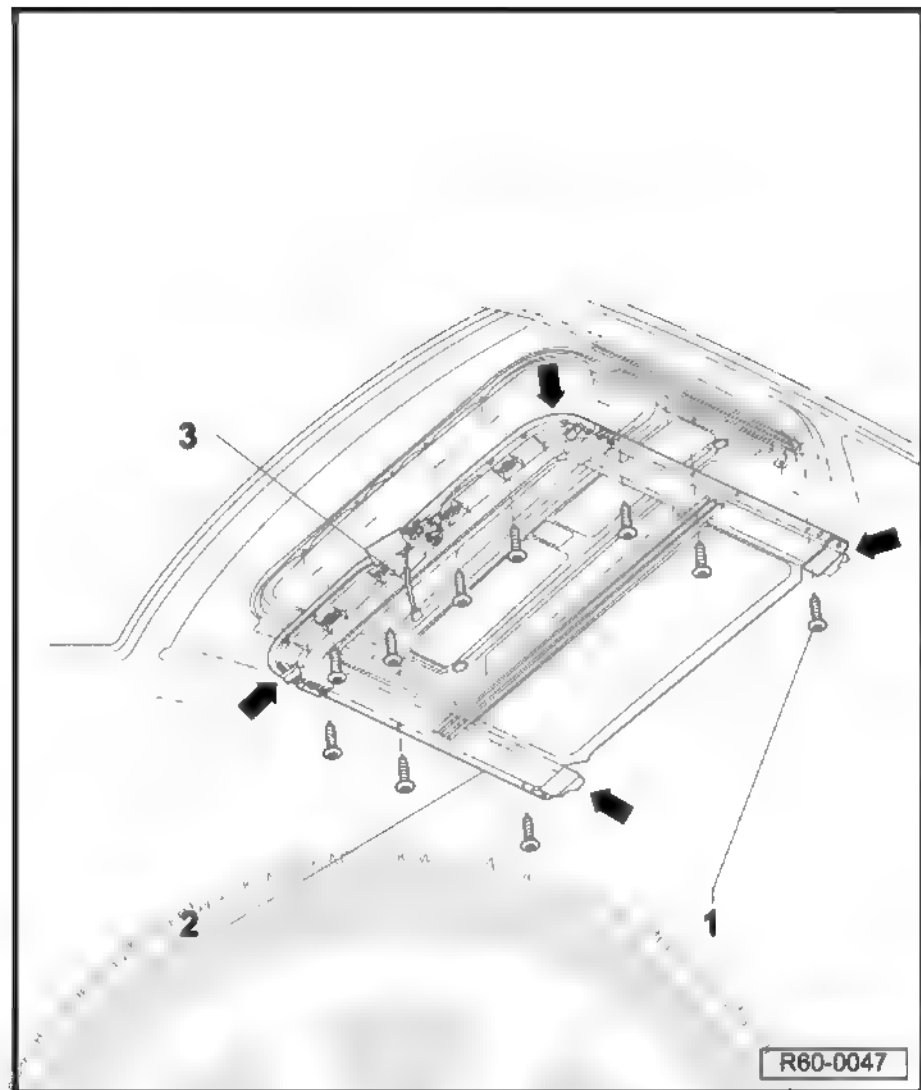


1.16.1 Remove

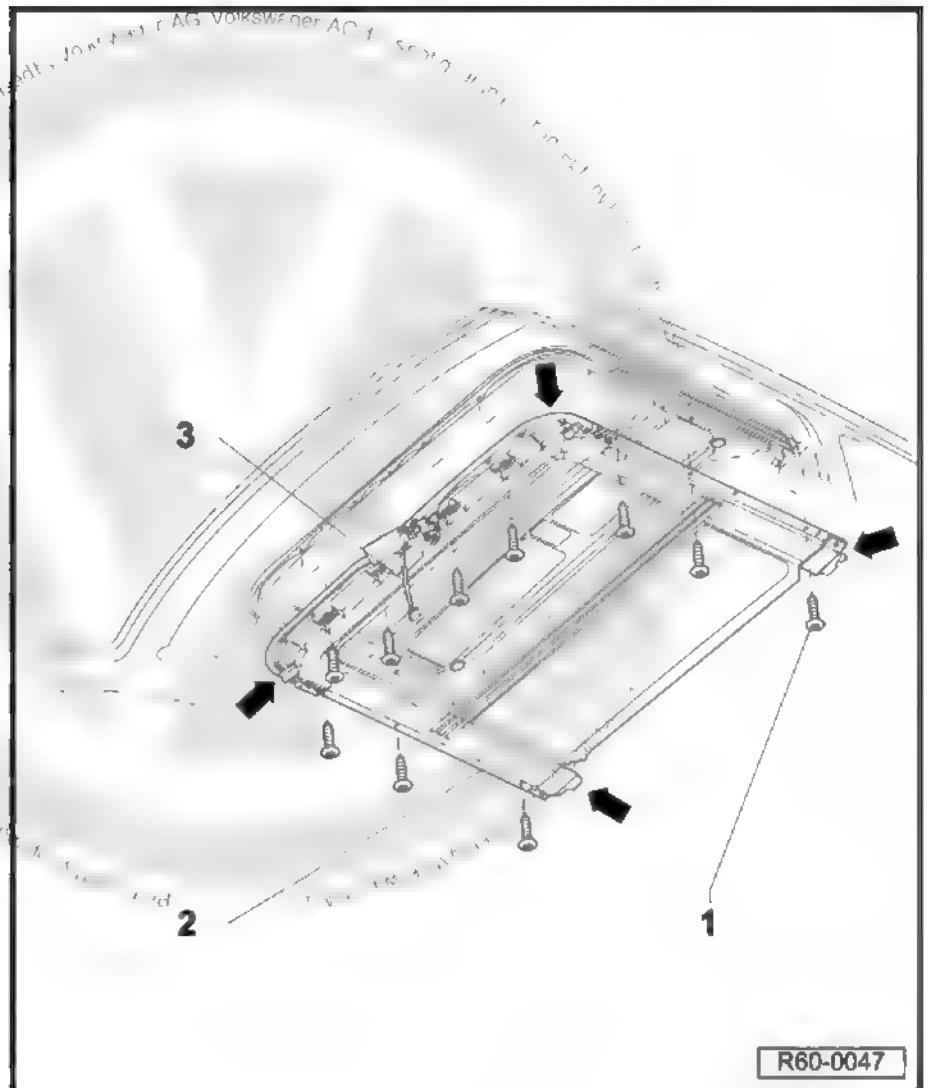
- Remove the glass lid from the sliding/tilting roof for better assembly.
- Remove roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations
- Disconnect harness from Sliding sunroof motor - V1- -3-.
- Disengage water drain hoses from guide frame-1- -arrows-.
- Remove screws -2- and guide frame from the vehicle, with the assistance of another mechanic



1.16.2 Install



- Support assembly unit -1- on rear housings and turn upwards (fastening pins must be inserted in assembly holes)
- Install the screws -2-
- Check positioning of roof cables and electrical consumers, and establish connection if necessary.
- Fastened assembly unit -1- of sliding/tilting sunroof activation -3-, from left and right to backwards (8 Nm).
- Install sliding sunroof activation motor connection -3-
- Install water drain flexible tubes -arrows-.



- Install shaped roof ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations .
- Install sliding/tilting sunroof glass lid.

1.17 Guide with steel cable - remove



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- Remove sliding/tilting sunroof glass lid.
- Remove sunroof
- Remove Sliding sunroof motor - V1- .
- Remove sliding device guides.



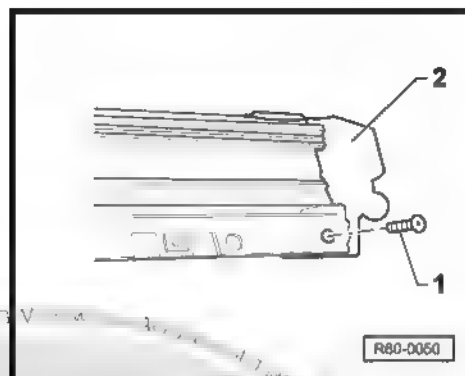
- Remove screw -1- and disengage tip -2-.



Note

Seal tip -1- with Butyl adhesive cord - AKL 450 005 05- in the opposite side from guide rail when installing.

- Pull guide with steel cable outwards



1.17.1 Assembly notes:



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

- ◆ Always replace guides with steel cable in pairs.
- ◆ Lubricate guide channels with special grease - G 000 450 02- .
- ◆ Install sunroof.
- ◆ Adjust parallelism.
- ◆ Install glass lid for sliding/tilting sunroof.

1.18 Drain hoses - clean

1.18.1 Front water drain hoses:

Front water drain hoses ⇒ [Item 2 \(page 123\)](#) pass throughout pillars A and end in the water case. Clean the hoses as from the sliding/3-way tipper cut-out



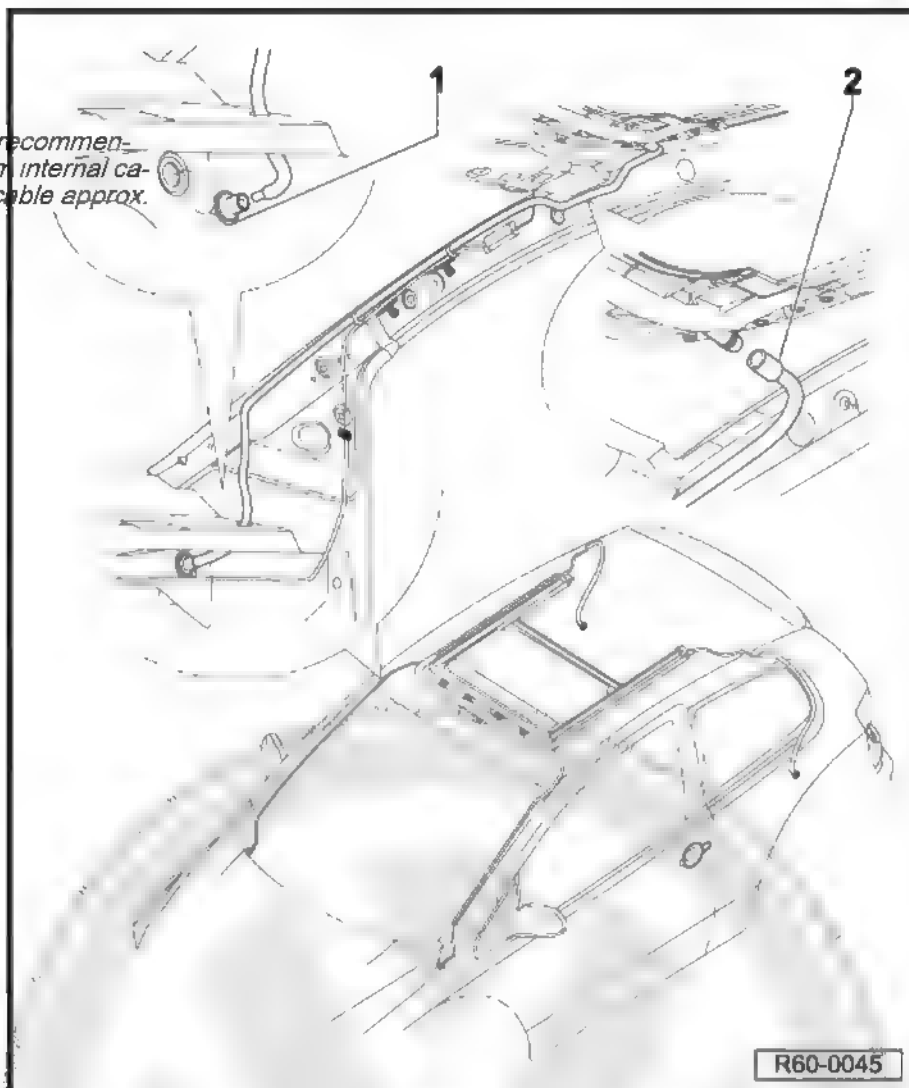
1 - Water drain valve



Note

A properly-built tool is recommended for cleaning as from internal cable of a speedometer cable approx. 2300 mm long

2 - Water drain hose



1.18.2 Rear water drain hoses:

Rear water drain hoses ⇒ [Item 3 \(page 124\)](#) pass through and end on the roof rear edge before rear lid. Clean as from hose rear edge. Remove cover to perform this.



1 - Water drain hose

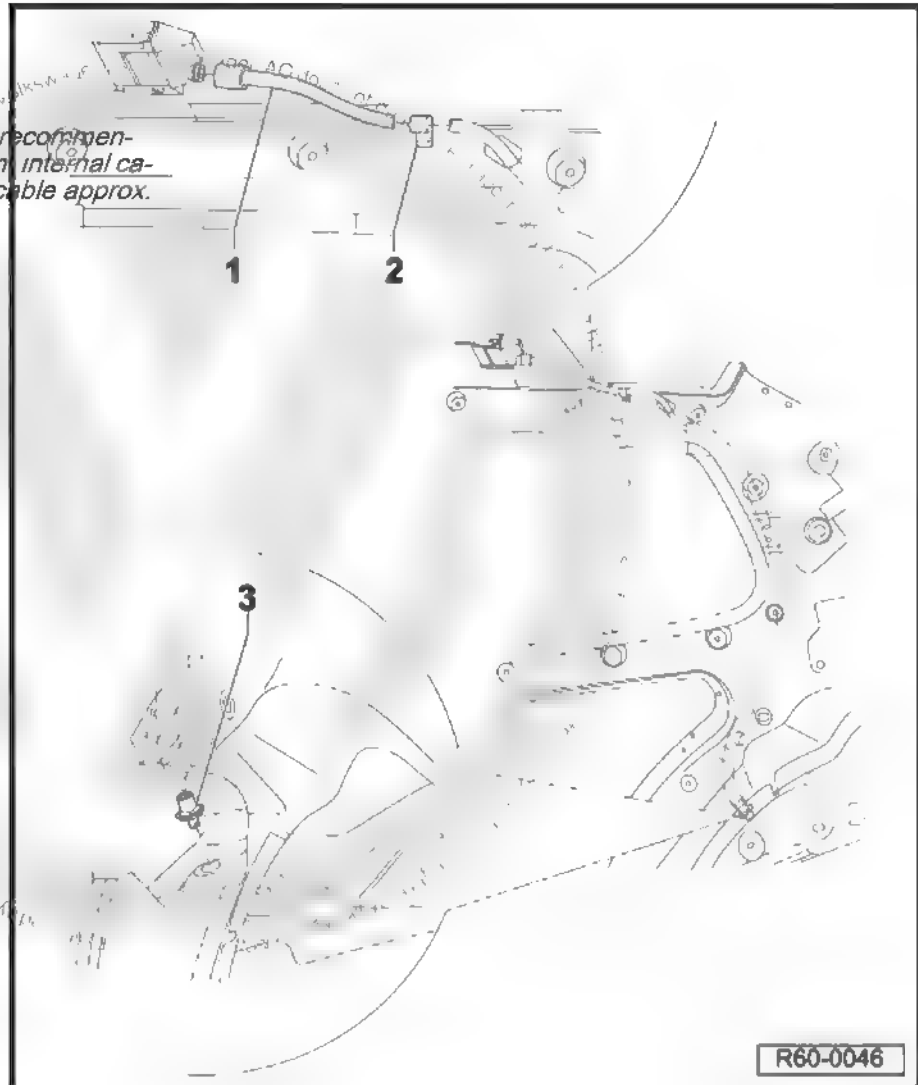


Note

A properly-built tool is recommended for cleaning as from internal cable of a speedometer cable approx. 2300 mm long.

2 - Clip

3 - Water drain valve





63 – Bumpers

Front bumper

1.1 Front protector - assembly overview

1 - Front protector

- ☐ remove ⇒ [page 126](#)

2 - Adjustment nut

- ☐ ► 03.04
- ☐ 2 units
- ☐ adjust with no tension

3 - Counter nut

- ☐ ► 03.04
- ☐ 2 units
- ☐ Torque: 6.5 Nm

4 - Front end

5 - Bolt

- ☐ 4 units
- ☐ Torque: 6.5 Nm

6 - Coupling nut

- ☐ 6 units

7 - Bolt

- ☐ 6 units
- ☐ Torque: 1.5 Nm

8 - Coupling nut

- ☐ 4 units

9 - Bolt

- ☐ 2 units
- ☐ 6.5 Nm

10 - Bolt

- ☐ 4 units
- ☐ Torque: 1.5 Nm

11 - Bolt

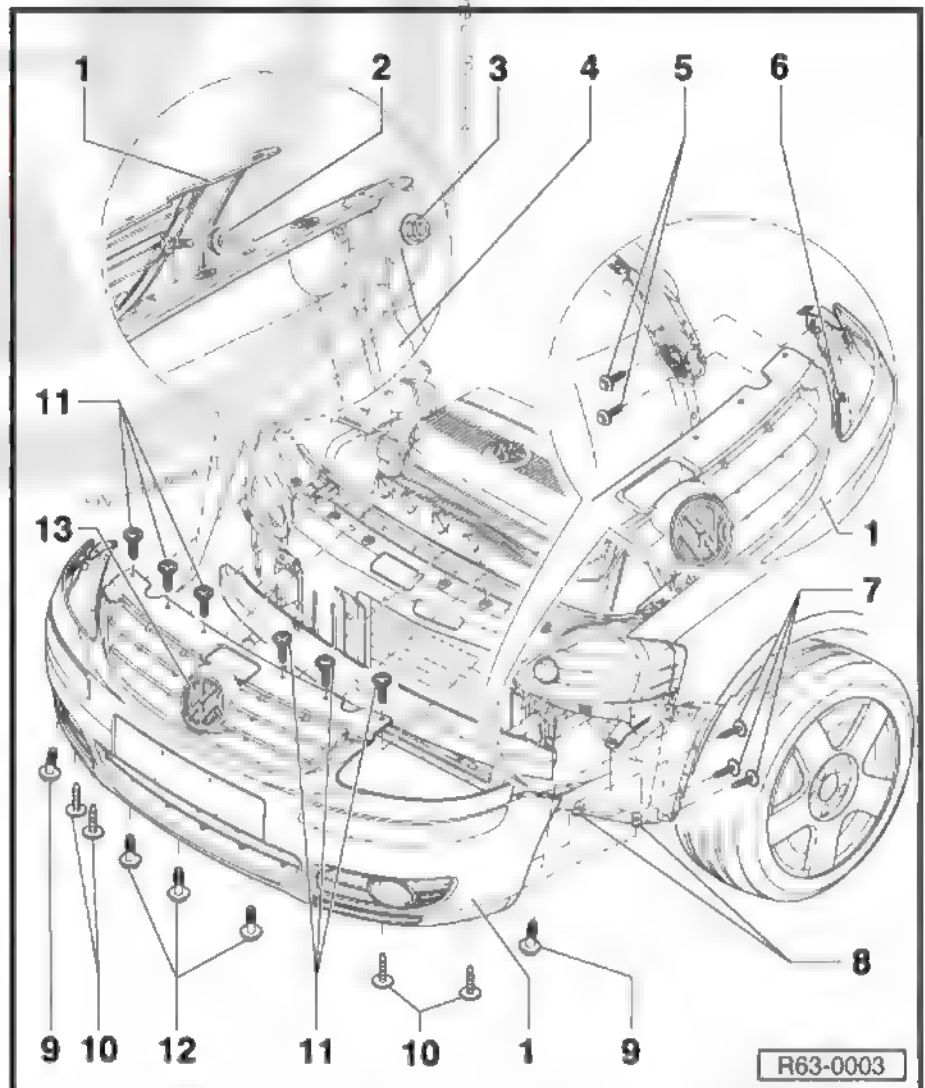
- ☐ 6 units
- ☐ Torque: 6.5 Nm

12 - Bolt

- ☐ 3 units
- ☐ Torque: 6.5 Nm

13 - Front VW badge

- ☐ fitted to the bumper covering

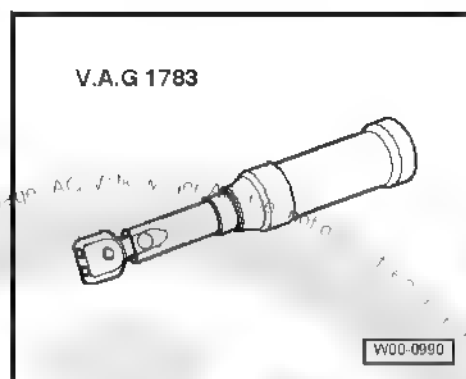




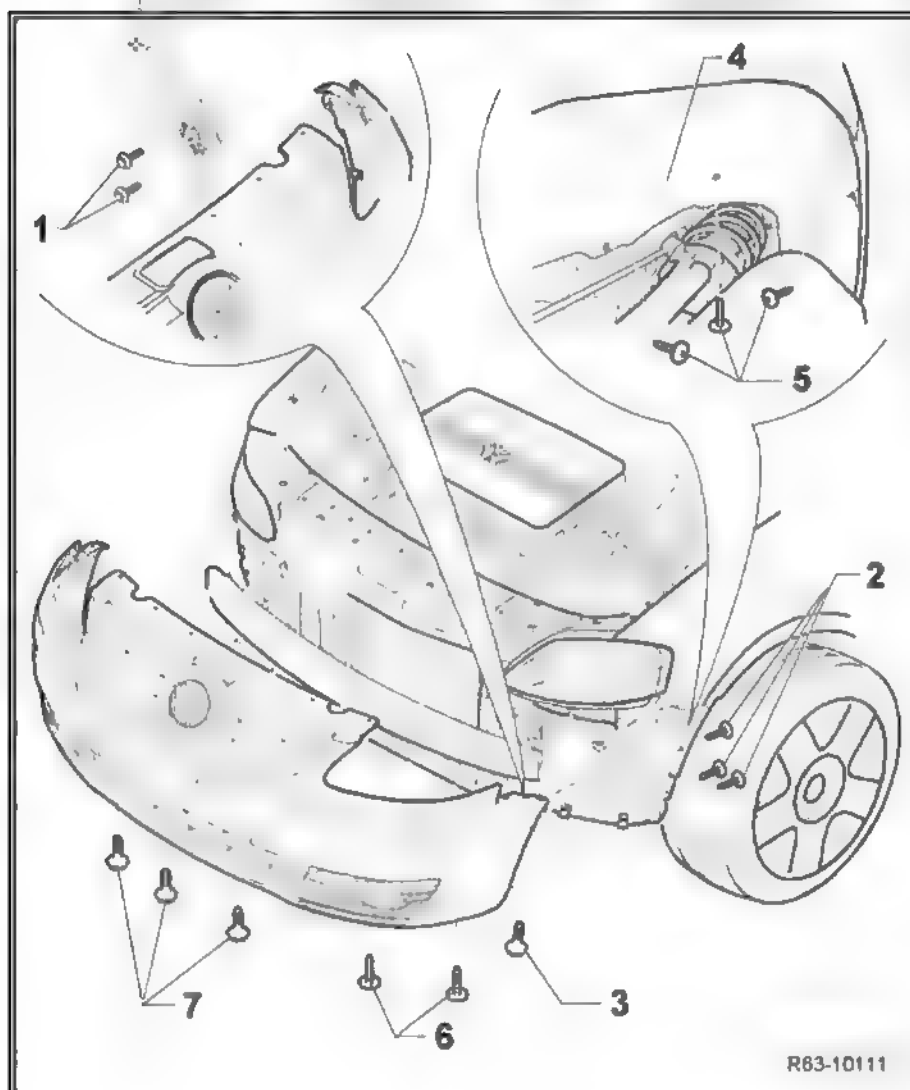
1.2 Front bumper protector - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-



1.2.1 Remove

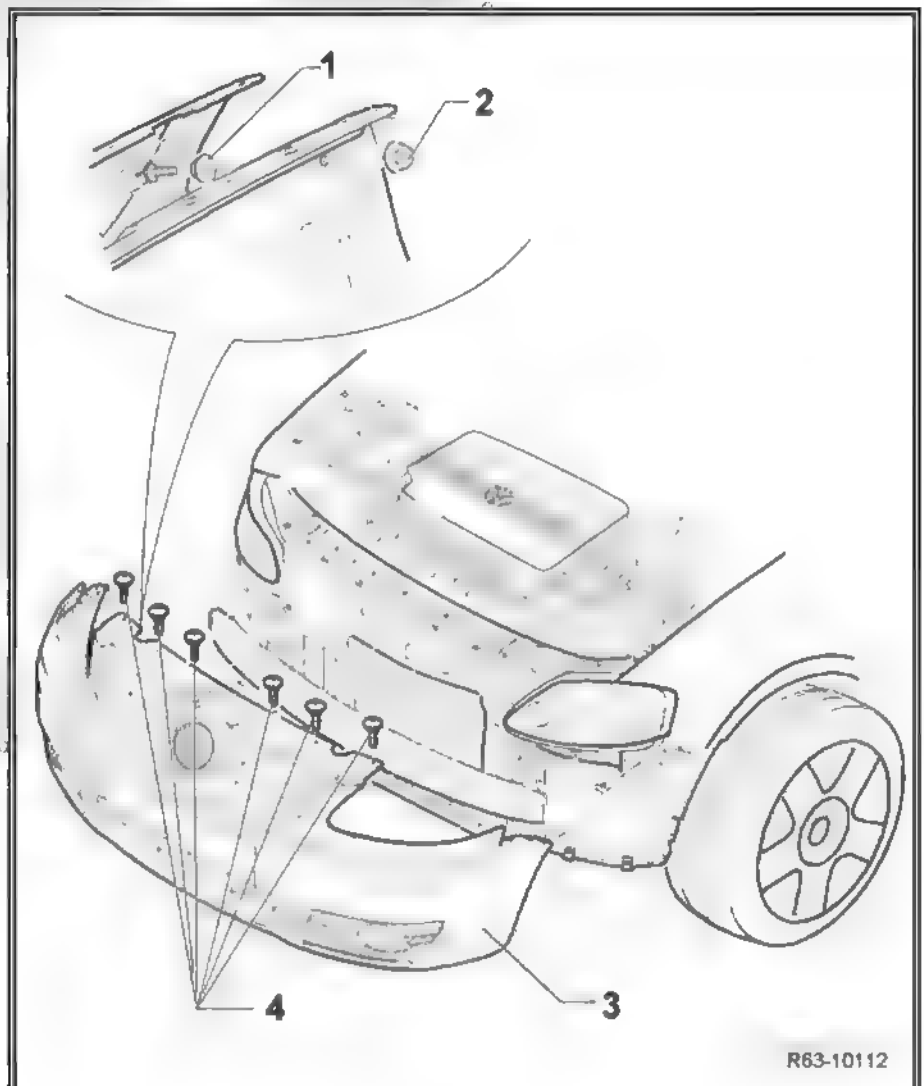




Note

For the CrossFox (► 2007), it is necessary to remove the fastening bolts -4- from the central protector cross member.

- Remove noise insulation
- Remove screws -2- and -5- (1.5 Nm) from wheel case protectors
- Remove screws -6- from the lower fastening of wheel case protectors.
- Remove screws -3- and -7-.
- Move the wheel case protector downwards and remove screws -3- and -1-.

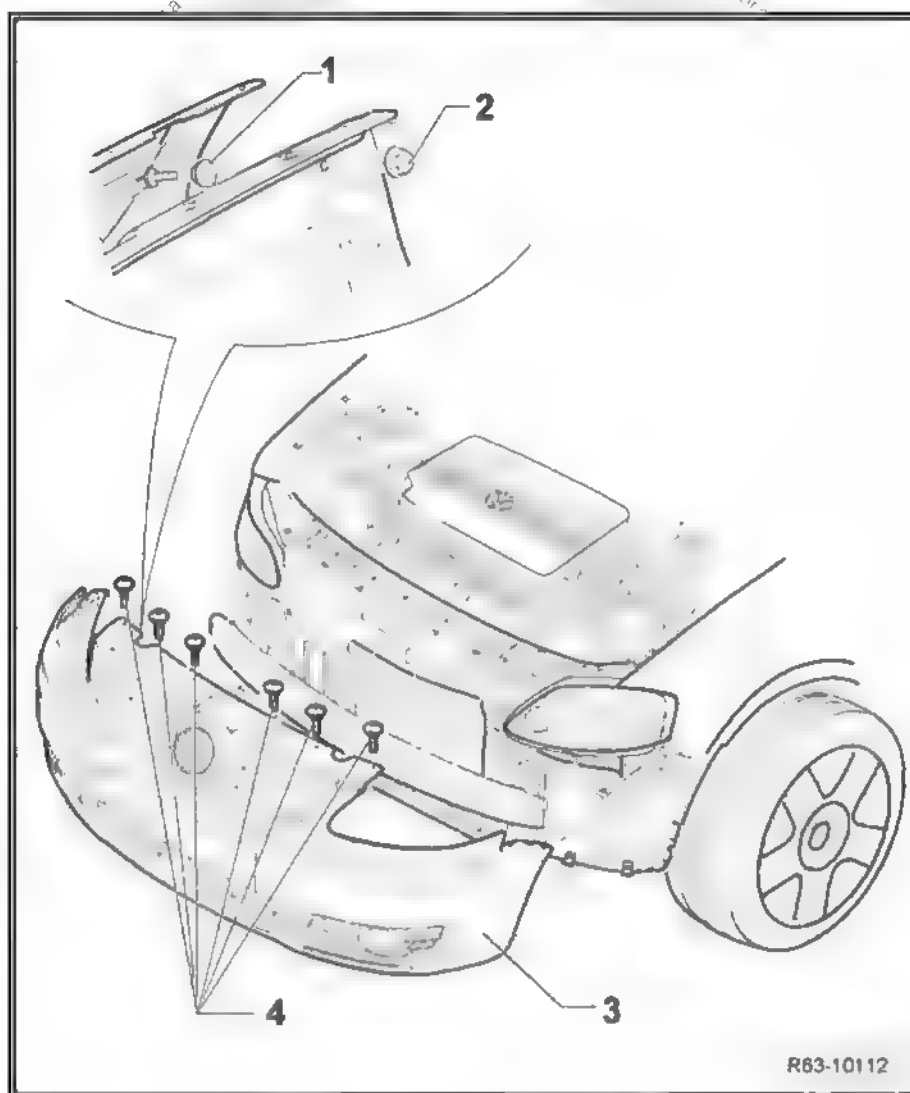


- Remove locknut -2- (► 03 04).
- Remove the bolts -4-.
- Carefully remove the bumper covering -3- forward.
- Disengage the electrical connectors (fog light, long-range headlights - CrossFox).

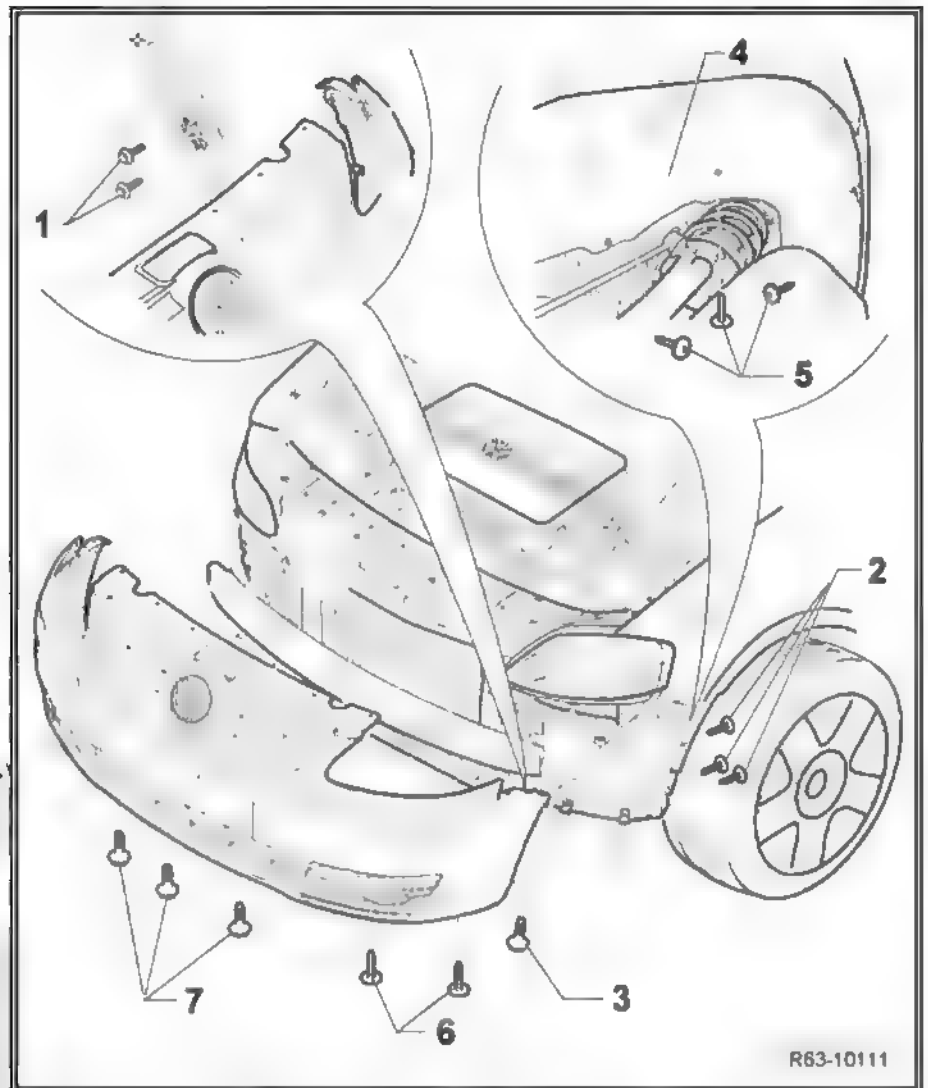


1.2.2 Install

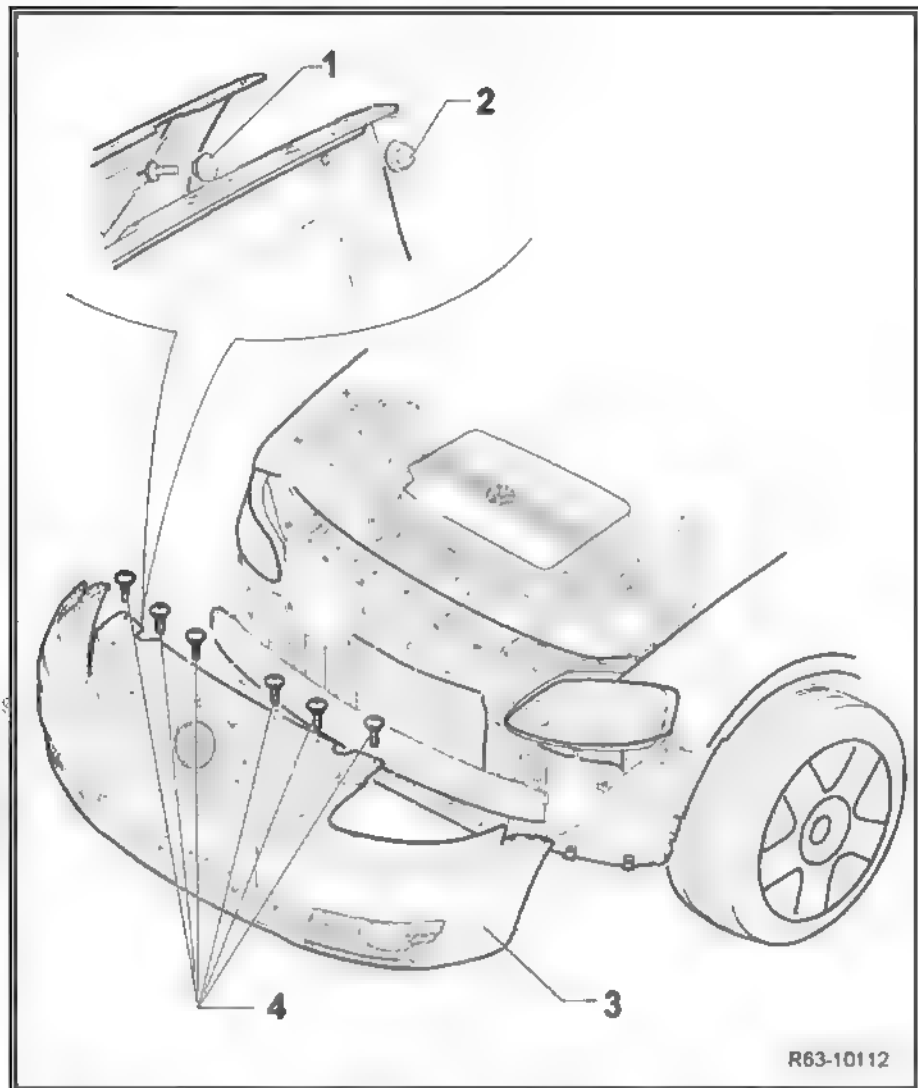
Install is performed in the reverse sequence, observing the following:



- Fasten the adjustment nuts -1- and -2- (➤ 03.04) to the front bumper threaded pins.
- Place the front bumper -3- and manually fasten the screws -4-.



- Manually fasten screws -3- and -7-.



- Align the front protector -3- in the elongated holes with the headlight housing and wing, by using the adjustment nuts (► 03.04)⇒ Body Repairs; Rep. gr. 00 ; Body clearance dimensions
- Turn the adjustment nuts without tensioning (► 03.04) against the front panel.
- Tighten all the screws definitively.



1.3 Front protector support - assembly overview

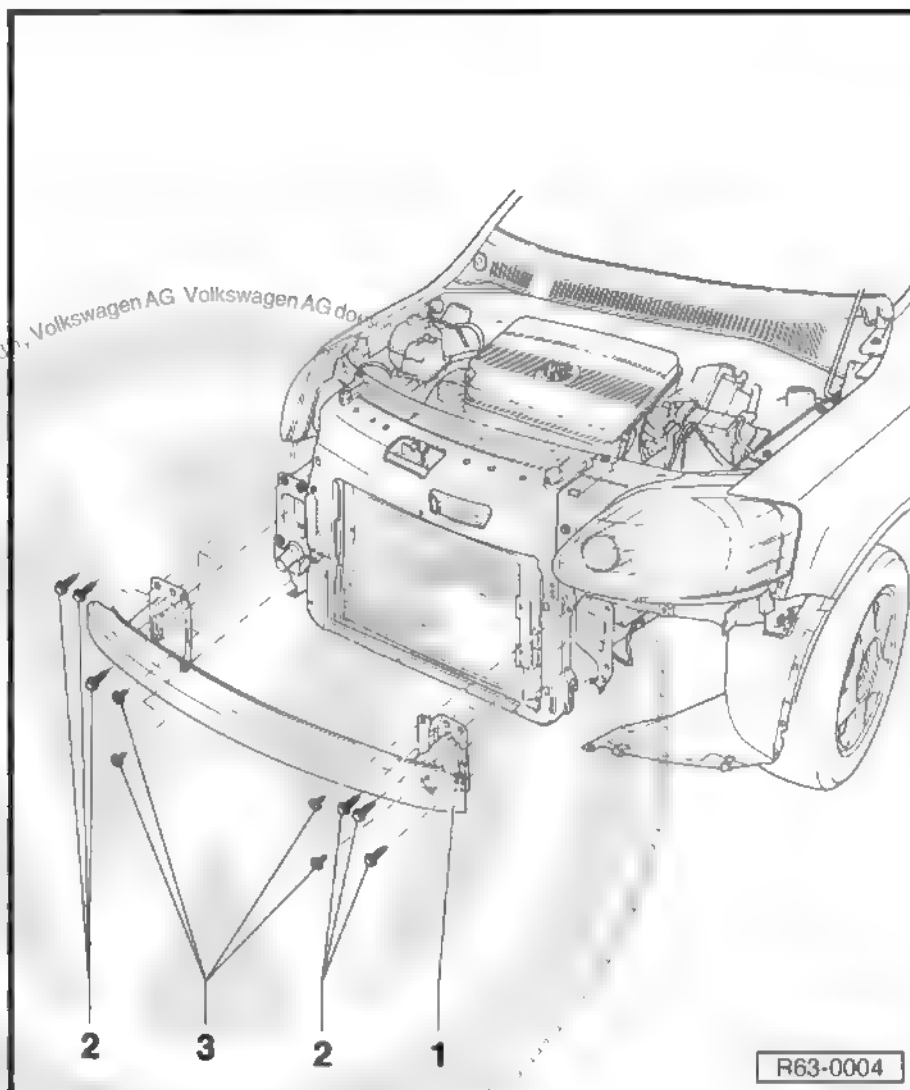
1 - Front protector support

2 - Bolt

- 6 units
- Torque: 35 Nm

3 - Bolt

- 4 units
- Torque: 8 Nm





2 Rear bumper (Fox)

2.1 Rear protector - assembly overview

1 - Guide part

- ☐ The bumper cover
⇒ [Item 2 \(page 132\)](#) is
fitted to the guide
groove

2 - Rear protector

- ☐ remove ⇒ [page 132](#)

3 - Bolt

- ☐ 3 units
- ☐ Torque: 6.5 Nm

4 - Number plate light

- ☐ fitted to the bumper cover-
ing

5 - Coupling nut

- ☐ 6 units

6 - Bolt

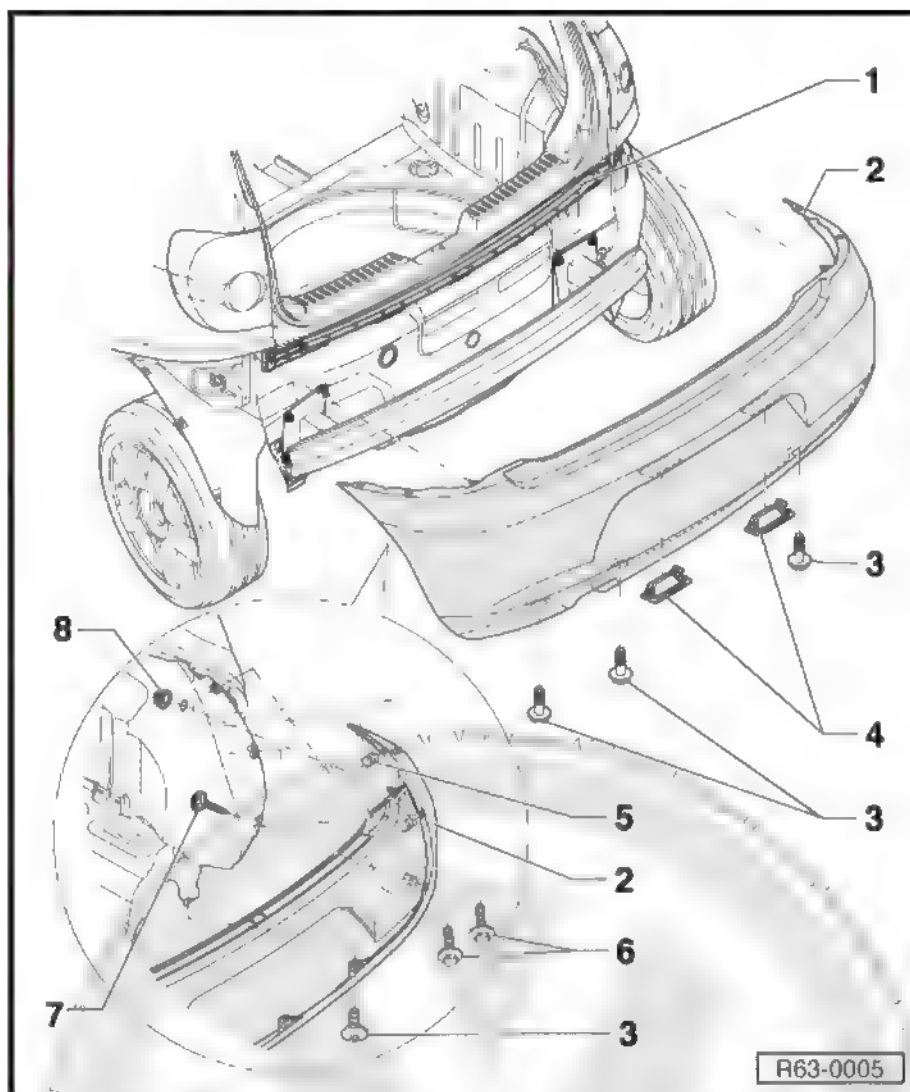
- ☐ 4 units
- ☐ Torque: 6.5 Nm

7 - Bolt

- ☐ 6 units
- ☐ Torque: 1.5 Nm

8 - Hexagonal nut

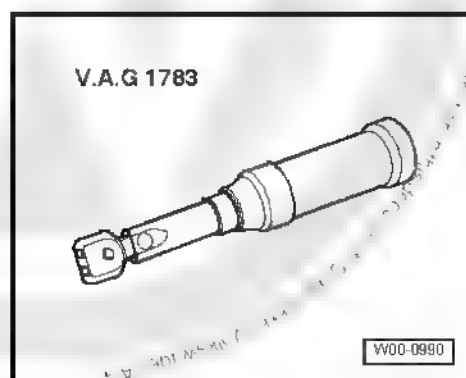
- ☐ 2 units
- ☐ Torque: 6.5 Nm

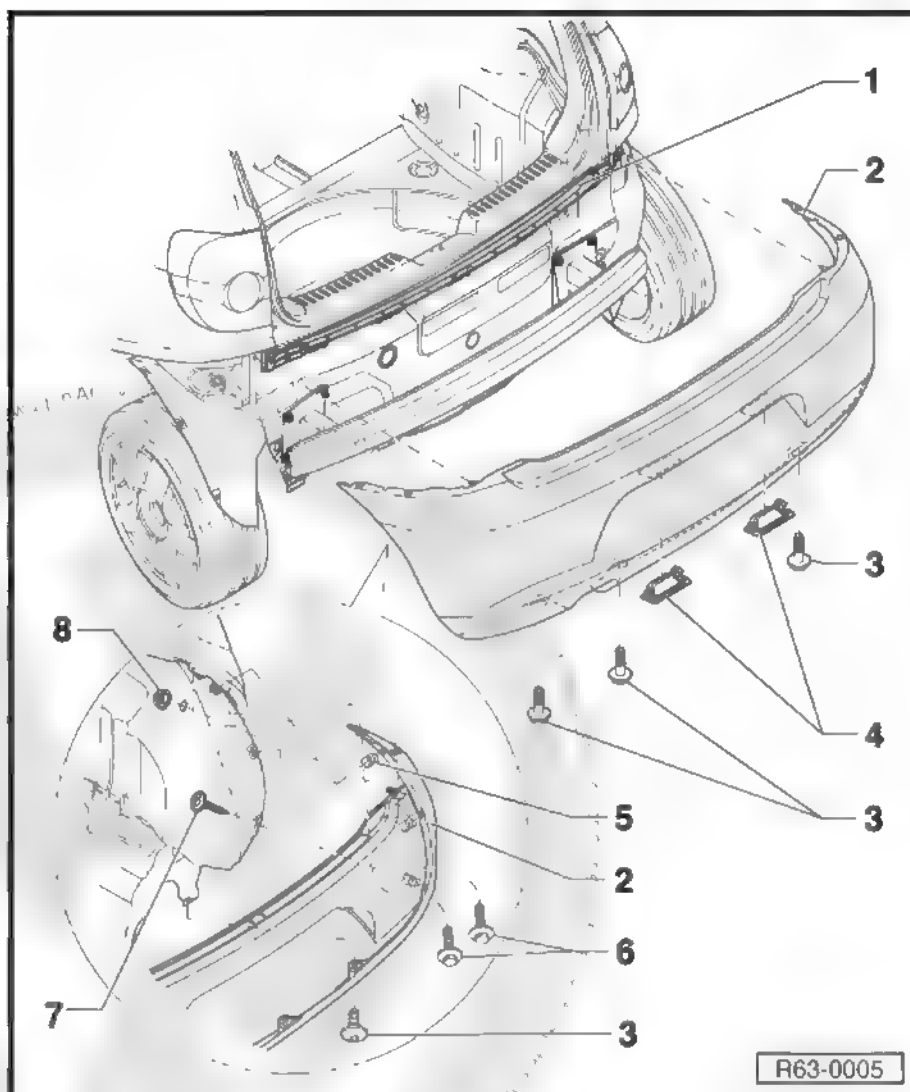


2.2 Rear protector - remove and install

Special tools and workshop equipment required

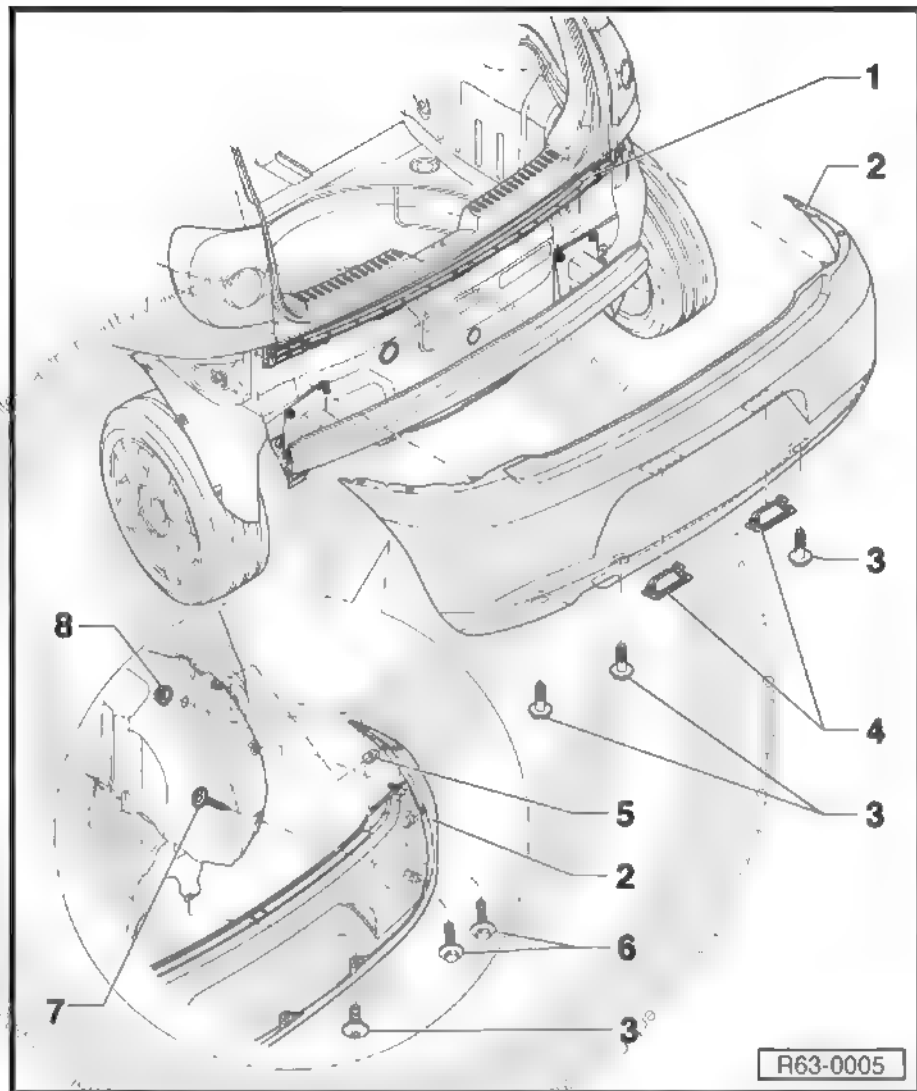
- ◆ Torque wrench 2 to 10 Nm - VAG 1783-





Remove

- Remove screws -7- from the wheel case protectors.
- Remove screws -6- and remove hexagonal nuts -8- in order to do that press wheel case protector aside or remove it to facilitate disassembly.
- Remove the bolts -3-.
- Carefully pull rear protector -2- out of the guide part groove -1-, also disconnect license plate light connectors



Install

Install is performed in the reverse sequence, observing the following:

- Carefully push rear protector -2- in the guide part groove -1- and also connect license plate light connectors.
- Manually fasten the hexagonal nuts -8-.
- Manually fasten screws -6- and -3-.
- Align the rear protector -2- in the elongated holes with the body
⇒ Body Repairs; Rep. gr. 00 , Technical data
- Fasten screws -6-, -3- and hexagonal nuts -8- with tightening torque of 6.5 Nm.

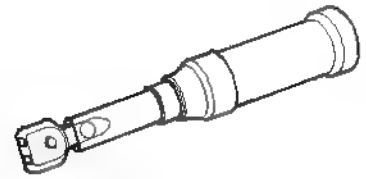
2.3 Rear protector support - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench 2 to 10 Nm - VAG 1783-

V.A.G 1783



W00-0990

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

V.A.G 1331



W00-0427



1 - Protector support

2 - Bolt

□ 7 units

□ Torque: 3 Nm

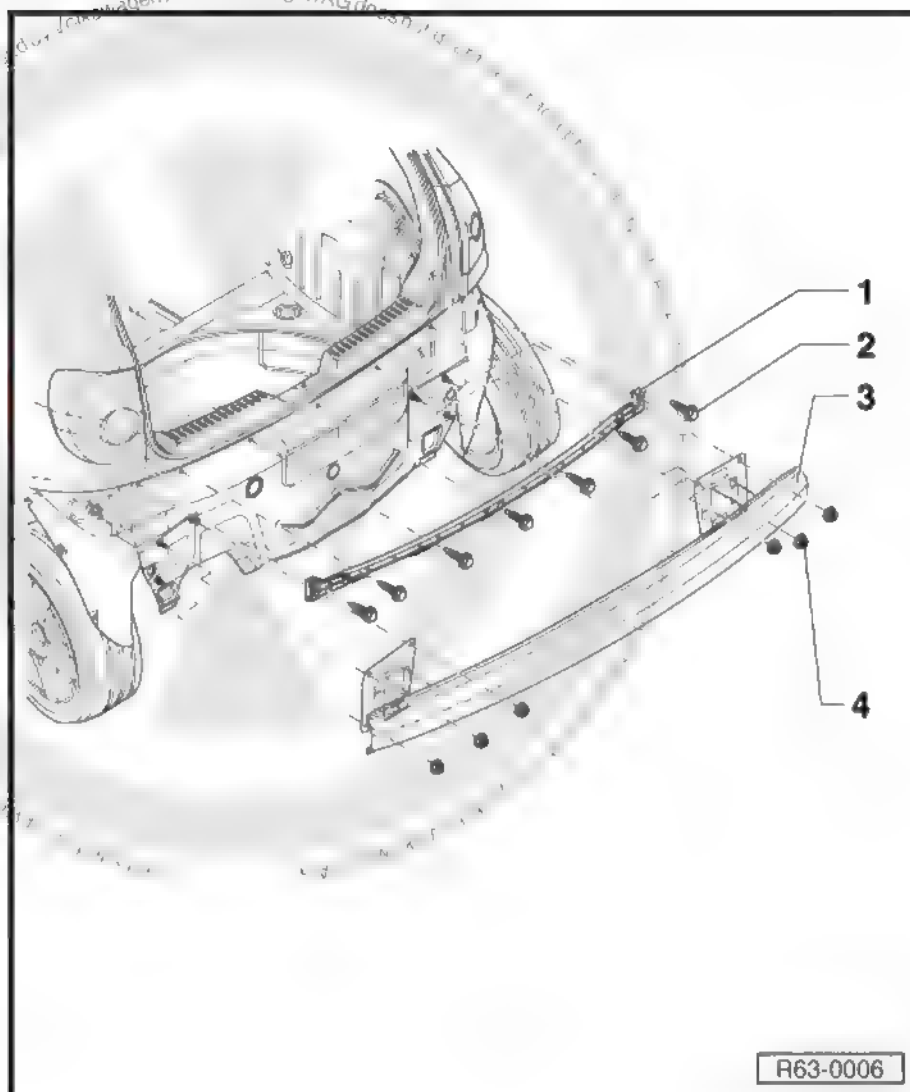
3 - Rear protector support

□ Remove the rear protector
⇒ [page 134](#)

4 - Hexagonal nut

□ 6 units

□ Torque: 20 Nm

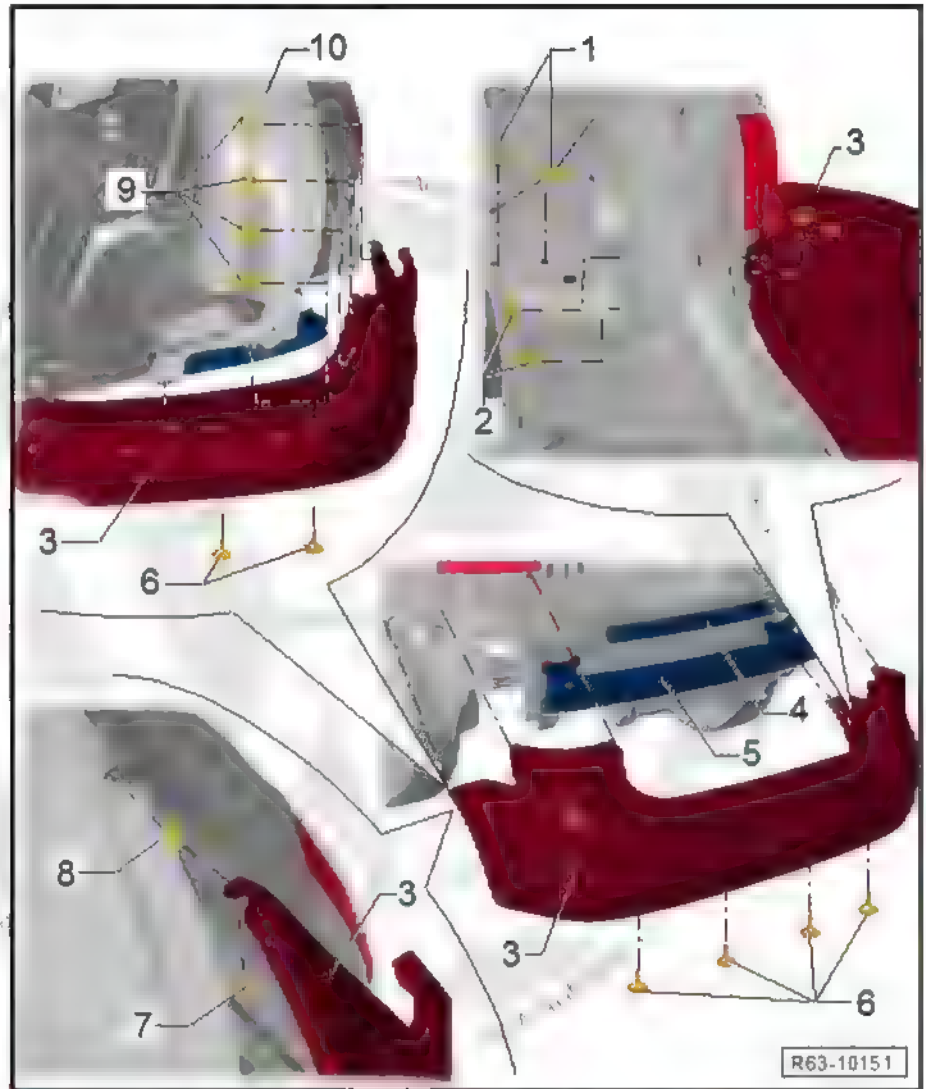




3 Rear bumper (Spacefox)

3.1 Rear bumper - assembly overview

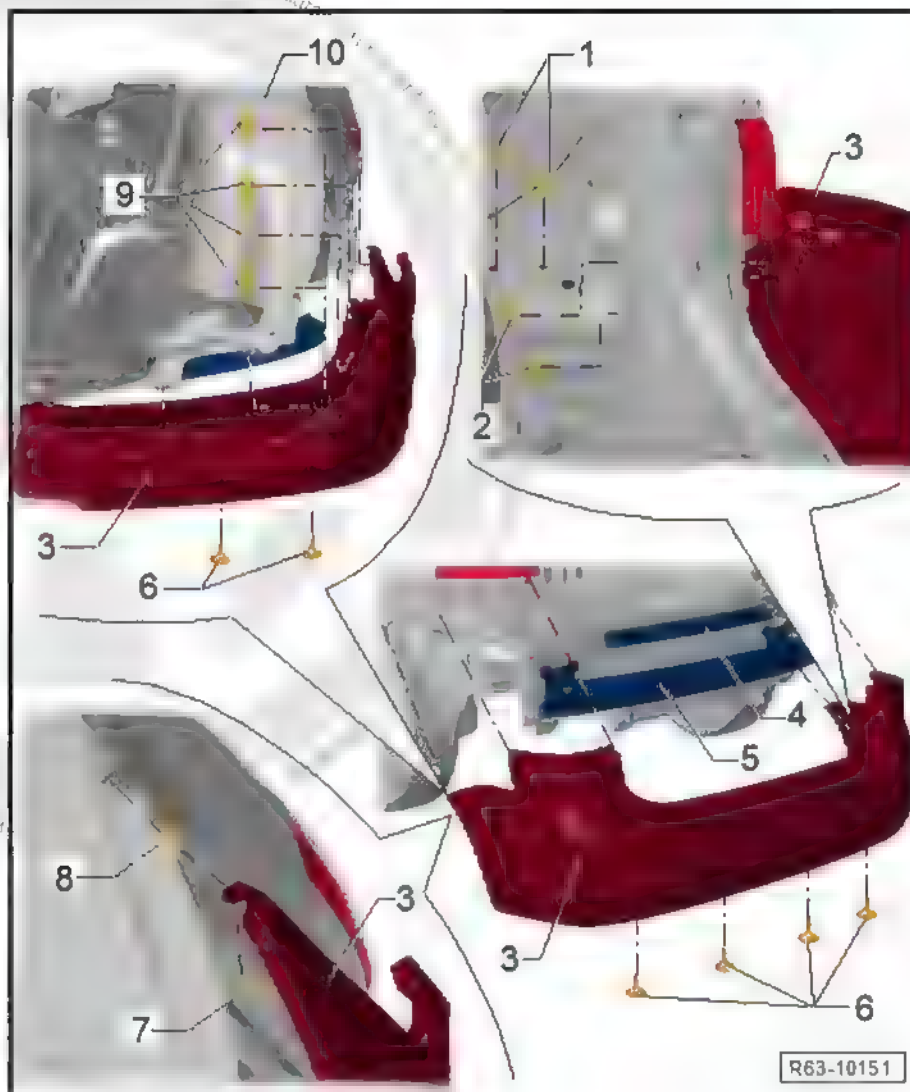
- 1 - Bolt
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 2 - Combined nut
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 3 - Rear protector
 - ☐ Remove and install
⇒ [page 138](#)
- 4 - Rear protector fitting support
 - ☐ remove rear protector .
- 5 - Rear protector support
 - ☐ remove rear protector .
- 6 - Bolt
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 7 - Bolt
 - ☐ 2 units
 - ☐ Torque: 1.5 Nm
- 8 - Plastic bushing
 - ☐ 2 units
- 9 - Rear wheel case protector
 - ☐ Remove and install
⇒ [page 255](#)
- 10 - Bolt
 - ☐ 8 units
 - ☐ Torque: 1.5 Nm





3.2 Rear protector - remove and install

3.2.1 Remove



- Remove the bolts -10- (8 parts).
- Remove the bolts -7- (2 parts).
- Remove the bolts -6- (4 parts).
- Remove the lining from the luggage compartment side cover .
- Remove the bolts -1- (4 parts).
- Remove nuts -2- (4 units).
- With the help of a second operator, pull the rear protector from both sides at the same time, to disengage the fitting support -4-.
- Disengage protector -3- from rear support -5-.



3.2.2 Install



Note

- ◆ *The rear protector supplied by Parts and accessories has already a base primer coating, and needs just finishing paint.*
- ◆ *Paint the protector ⇒ Paint Manual - Paint repairs on plastic parts in case of replacement.*
- Installation is performed in the reverse sequence to the removal.
- Check the clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data; Body clearance dimensions before applying torque to the screws and bolts.

3.3 Rear protector support - assembly overview

1 - Pop rivet nut M5

- ☐ 3 units
- ☐ Install with the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422- .

2 - Rear protector support

- ☐ Remove rear protector .

3 - Bolt

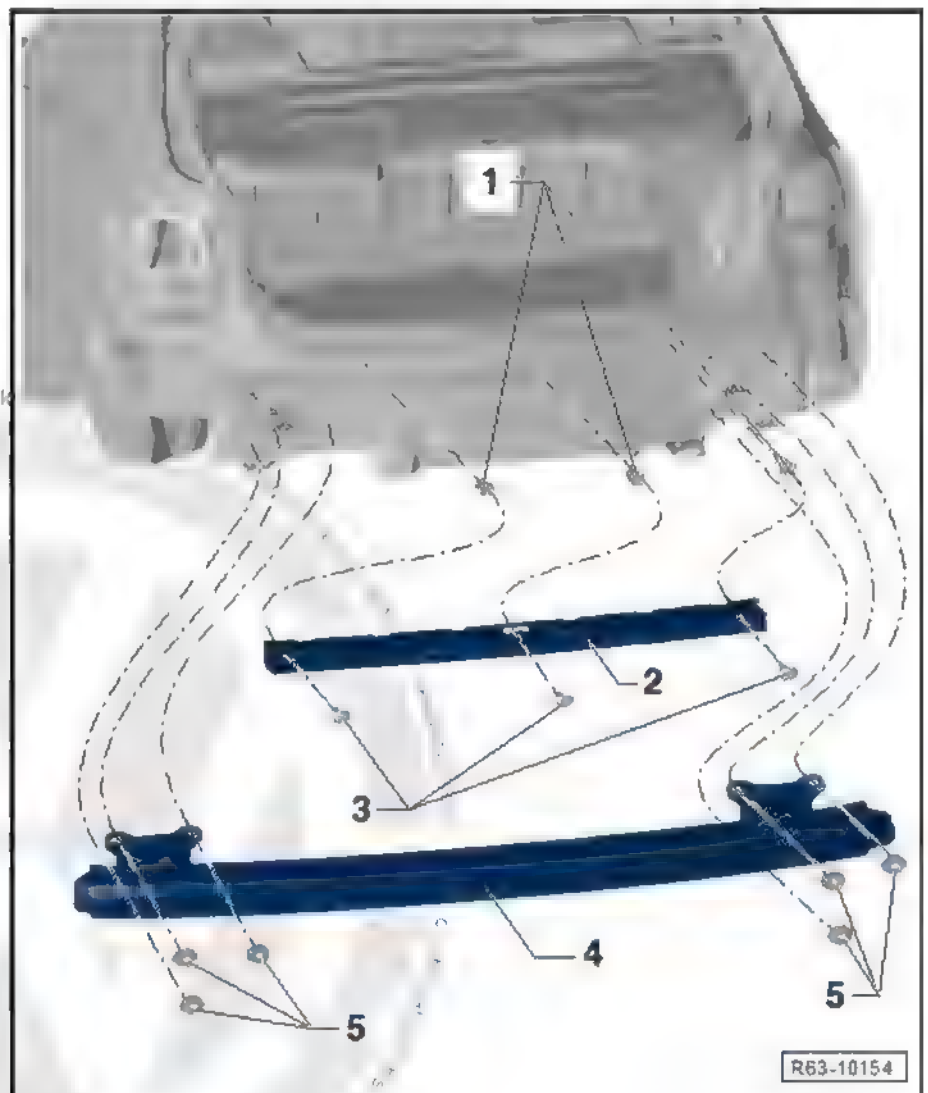
- ☐ 3 units
- ☐ Torque: 3.0 Nm

4 - Rear protector fitting support

- ☐ Remove rear protector .

5 - Nut

- ☐ 6 units
- ☐ Torque: 20 Nm



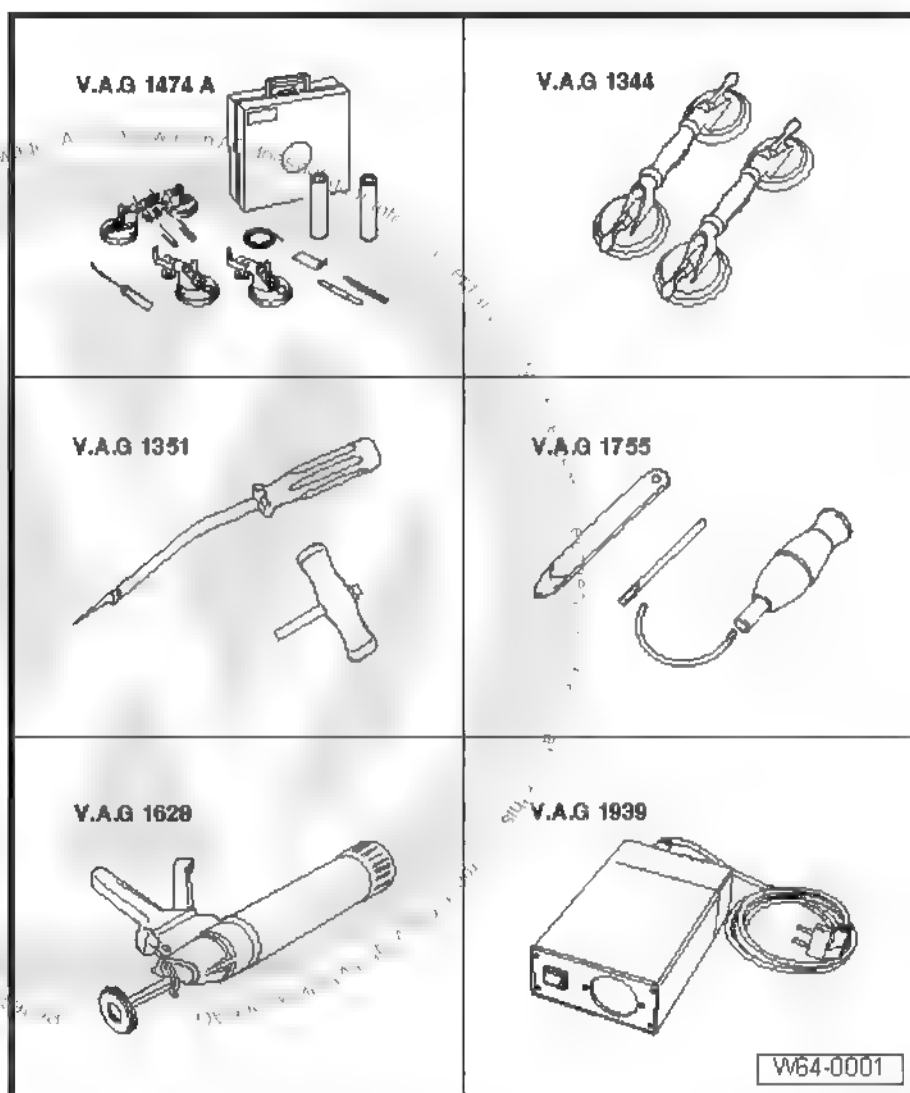


64 – Glazing

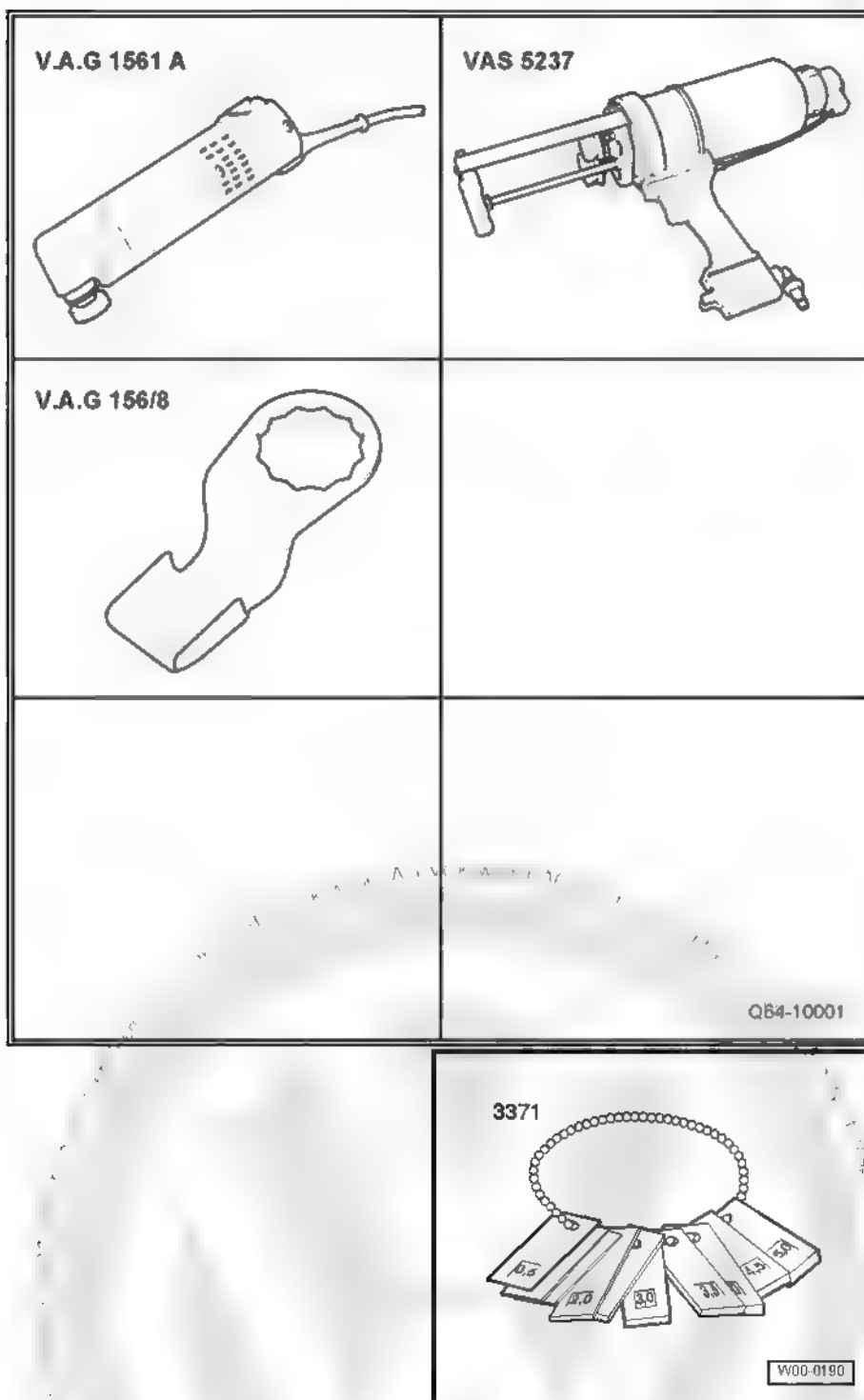
1 Glasses glued with adhesive

1.1 Tools

Special tools and workshop equipment required



- ◆ Glued glass removal kit - VAG 1474B-
- ◆ Suction pads - V.A.G 1344-
- ◆ Anchoring tool - VAG 1351- and Handle - VAG1351/1-
- ◆ Glass removal kit - V.A.G 1755-
- ◆ Manual pressure gun - V.A.G 1628-
- ◆ Device with ratchet - VAG 1654A-
- ◆ Panel protection film - VAG 1474/8-
- ◆ Cartridge heater - V A.G 1939-



- ◆ Electric adhesive bead cutter - glued windows - VAG 1561A-
- ◆ 15 mm blade - VAG 1561/8-
- ◆ Pneumatic adhesive applicator - VAS 5237-
- ◆ Adjustment gauge - 3371-



1.2 Auxiliary materials for Brazilian market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- ◆ PU 1K Adhesive Betaseal U 400 HV - ⇒
Chemicals Manual;
Rep. gr. 00 ; Chemicals
Manual - List of author-
ized products ^{1, 3, 4}
- ◆ Body Primer Betaprime 5404 - ⇒
Chemicals Manual;
Rep. gr. 00 ; Chemicals
Manual - List of author-
ized products ³
- ◆ Glass Primer Betaprime 5500 - ⇒
Chemicals Manual;
Rep. gr. 00 ; Chemicals
Manual - List of author-
ized products ³
- ◆ Cutting wire 357 853 999 A (1.25 x
6000 mm)
- ◆ Glass adjustment shim 443 845 631 A ²
- ◆ Cleaning solution D 009 401 04 ³

6) Heat up with the cartridge heater - V.A.G 1939- .

7) It must be removed two hours after assembling the windscreen

8) Observe the procedural indications in accordance with the manufacturer's pre-
scriptions for packaging disposa

9) Follow the minimum curing time ⇒ [page 160](#) .

1.3 Auxiliary materials for export market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- ◆ 2K- PU Adhesive DA 004 600 A2 ^{1, 2, 3, 5}
- ◆ 1K- PU Adhesive DH 009 100 ^{2, 3, 5}
- ◆ Activator D 181 802 M1 ^{3, 5}
- ◆ Glass / body primer D 009 200 02 ^{3, 5}
- ◆ Cleaning solution D 009 401 04 ^{3, 5}
- ◆ Primer applicator D 009 500 25
- ◆ Adhesive remover D 002 000 10 ^{3, 5}



- ◆ Cutting wire 357 853 999.A (1.25 x 6000 mm)
- ◆ Glass adjustment shim 443 845 631 A ⁴

10) In order to apply the adhesives in the set DA 004 600 A2- you must use the pneumatic adhesive VAS 5237


11) Heat with the cartridge heater - V.A.G 1939- according to the manufacturer's instructions

12) Observe the procedural indications in accordance with the manufacturer's prescriptions for packaging disposal

13) It must be removed two hours after assembling the windscreen

14) Follow minimum adhesive curing time ⇒ [page 160](#)

1.4 Matching table

 **WARNING**

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Note

To help understanding, please find below a comparison table for materials used in the Brazilian and export markets

Product	Brazilian Market	Export Market
Activator PU Adhesive	Betaseal U-400 HV	D 181 802 M1 DH 009 100 300 ml - DA 004 600 A2 (double car- tridge)
Glass primer	Betaprimer 5500	D 009 200 02
Body primer	Betaprimer 5404 A	D 009 200 02

1.5 Stickers for engraving the VIS number on the windows (only for Brazil) - supply

 **WARNING**

These labels are valid only for the Brazilian market.

The stickers for etching the VIS number on the windows upon request. On the Network Portal, under "After Sales", "Sist. Service Information System", the Memorandum no. 98/09 of 06/16/2009 "Engraving the chassis number (VIS) on windows and labels (VIS) on wheel housing, B-pillar and front underbody" can be found and that explains how to do it.

1.6 Windscreen - assembly overview



1 - Dimension a = 3 mm

- ☐ laterally

2 - PUR adhesive bead

- ☐ Adhesive bead cross-section width: -6...7 mm-
- ☐ Adhesive bead cross-section height: -9...11 mm- (including base adhesive layer on glass and glass flange)
- ☐ Minimum curing time ➔ [page 160](#)

3 - Dimension b = 2.5 mm

- ☐ on top

4 - Self-adhesive spacer shim

- ☐ 3 units
- ☐ adhesive spacer shim - 520 845 237-
- ☐ Glue on body before installing the windscreen.

5 - Windscreen

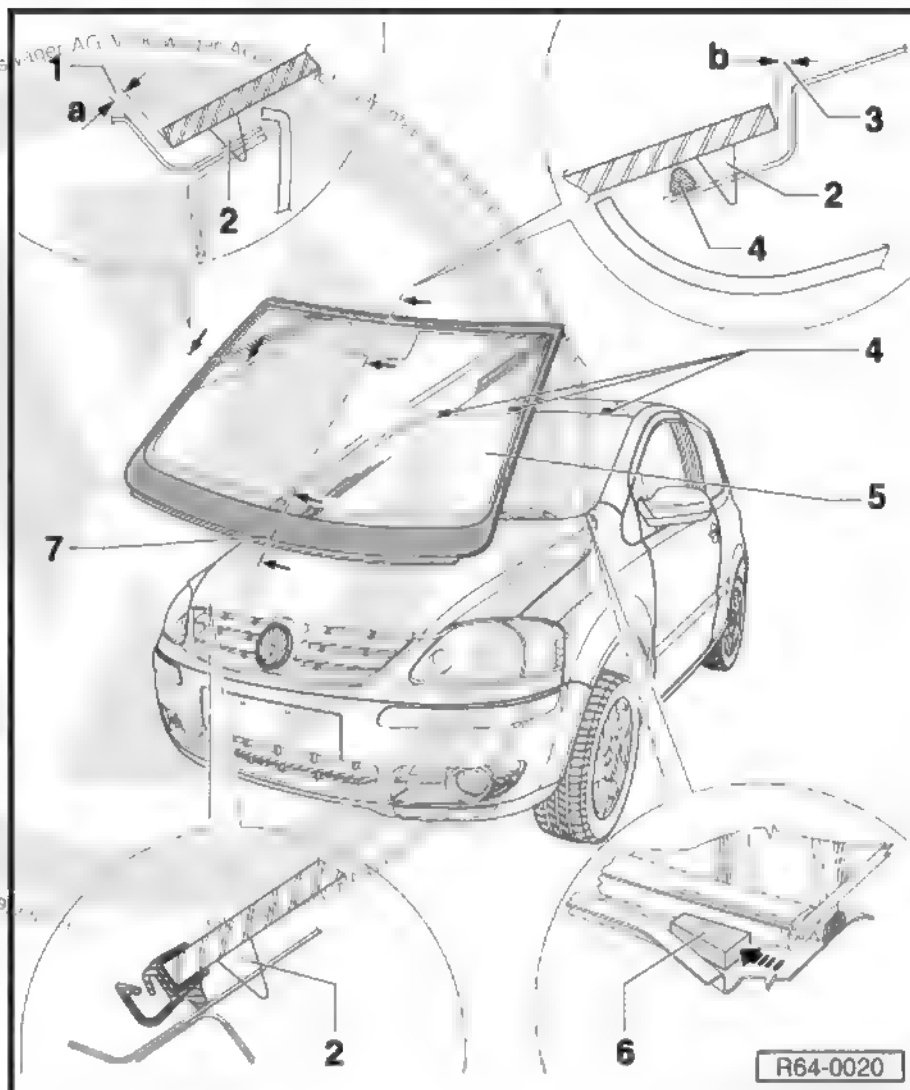
- ☐ Remove the windscreen ➔ [page 144](#)
- ☐ Install the windscreen ➔ [page 145](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only) ➔ [page 143](#)

6 - Glass adjustment shim

- ☐ Replacement parts number -443 845 631 A-
- ☐ Remove after adhesive curing

7 - PUR adhesive cord connection point

- ☐ PU adhesive application start and end.

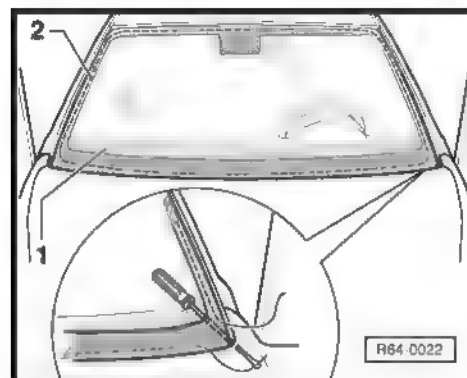


1.7 Windscreen - remove

- Remove the pillar A linings ➔ Body - Internal assembly works; Rep. gr. 70 ; Lining / insulation
- Remove the sunshades ➔ Body - Internal assembly works; Rep. gr. 68 ; Internal equipment
- Remove the internal rear-view mirror ➔ Body - Internal assembly works; Rep. gr. 68 ; Internal equipment



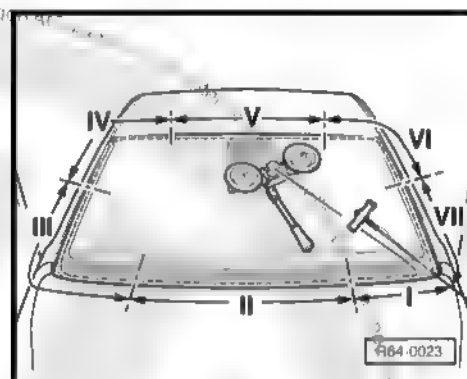
- Insert a protective film on dashboard - VAG 1474/8- -1- - V.A.G 1474/8- between windscreen and dashboard.
- If needed, place cutting wire -357 853 999 A- -2- with the aid of a tube (from the glass removal kit - V.A.G 1755-) on the glass flange.
- On areas with little clearance, you must distribute the cutting wire on the outside and press under the lip with a plastic wedge .
- Pull the cutting wire -357 853 999.A- with the perforating tool - VAG 1474/2- (from the glued glass removal kit - VAG 1474B-) through the adhesive cord from inside the vehicle.



Note

Lead the perforating tool - VAG 1474/2- on the glass side as close as possible to the body glass flange through the adhesive cord so that the sealing lip is not damaged.

- Fasten the cutting wire tip -357 853 999.A- to the device with ratchet - VAG 1654A- .
- Pull the second cutting wire tip -357 853 999.A- inwards and place the handle (from the anchoring tool - VAG 1351-) to hold it.
- Place the device with ratchet - VAG 1654A- in "position I".
- Transfer the device with ratchet - VAG 1654A- to "position II" as the adhesive gets cut.
- During the cutting (separation), press the cutting wire -357 853 999.A- against the glass with a plastic wedge -VAG 1474/5- to obtain free passage on the glass flange and the dash panel.
- Remove the glass with the suction pads - V.A.G 1344- .



1.8 Windscreen - install

Prepare the undamaged glass to be installed ⇒ [page 156](#) .

Prepare the new glass to be installed ⇒ [page 157](#) .

Prepare the body flange for putting the glass ⇒ [page 158](#) .

Assembly instructions ⇒ [page 159](#) .

Minimum adhesive curing time ⇒ [page 160](#) .

1.9 Side glasses (Fox 2-door) - assembly overview



1 - Glass internal packing

- ☐ fitted to the fitting flange
- ☐ in case of replacement, install with slight hits with a rubber hammer
- ☐ Install glass internal packing ➤ [page 147](#)

2 - Side window

- ☐ Remove side glass ➤ [page 146](#)
- ☐ Install side glass ➤ [page 148](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only) ➤ [page 143](#)

3 - Ceramic painting

- ☐ around glass from internal side

4 - PUR adhesive bead

- ☐ Adhesive bead cross-section width: 7.5.. 8.5 mm
- ☐ Adhesive bead cross-section height: 13...15 mm (including remaining material on glass and glass flange)
- ☐ Minimum curing time ➤ [page 160](#)

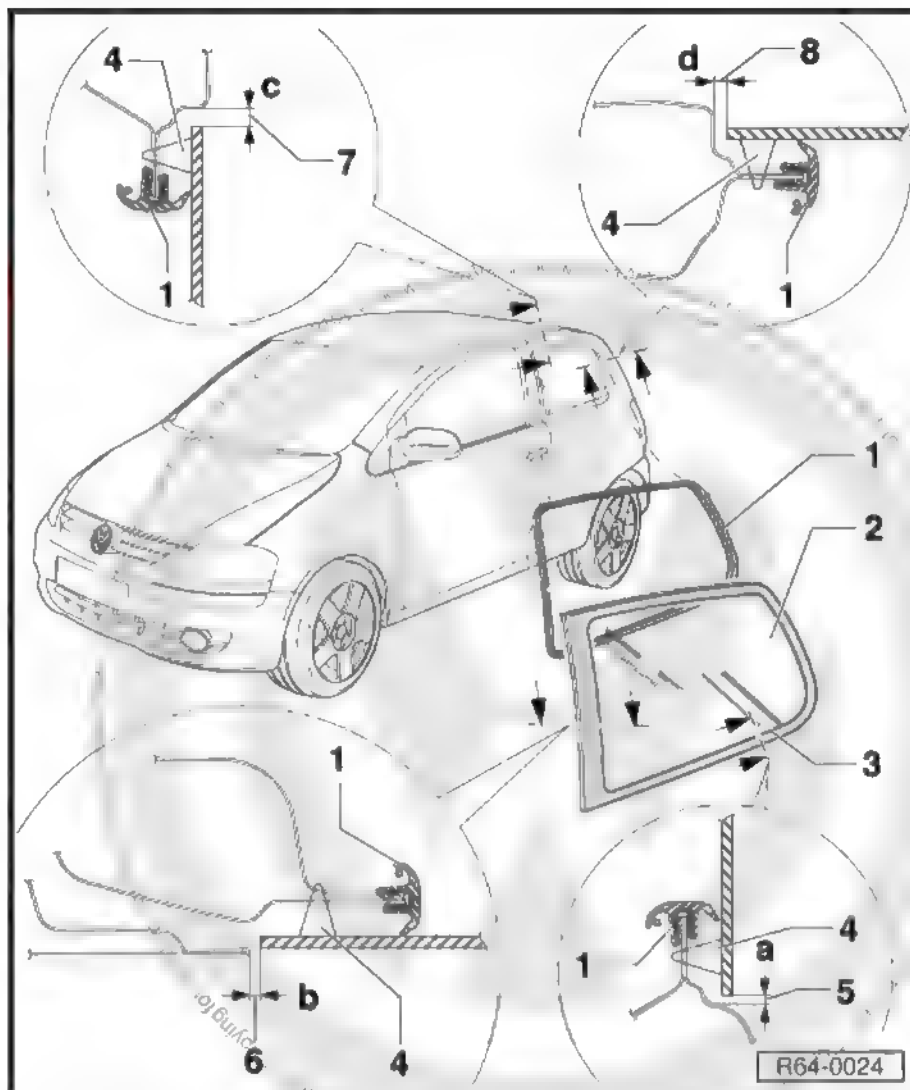
5 - Dimension a = 3 mm

6 - Dimension b = 3 mm

7 - Dimension c = 4.5 mm

- ☐ clearance dimension must be follow for distance is necessary for main roof support fastening

8 - Dimension d = 3 mm

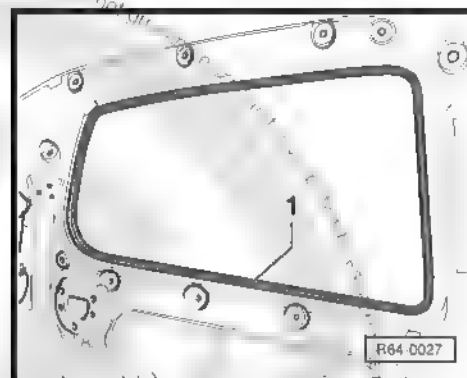


1.10 Undamaged side glass (Fox - 2-door) - remove

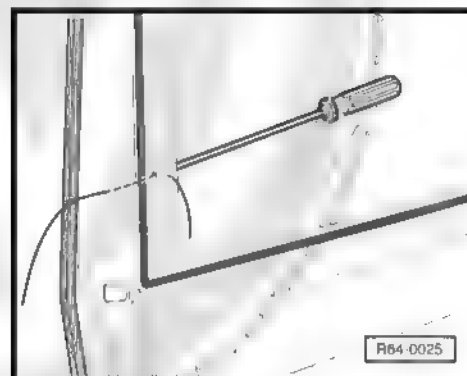
- Remove linings ➤ General body repairs, interior; Rep. gr. 70 ; Linings / insulations .
- Remove B-pillar linings ➤ General body repairs, interior; Rep. gr. 70 ; Linings / insulations
- Remove the C-pillar lining ➤ General body repairs, interior; Rep. gr. 70 ; Linings/insulation



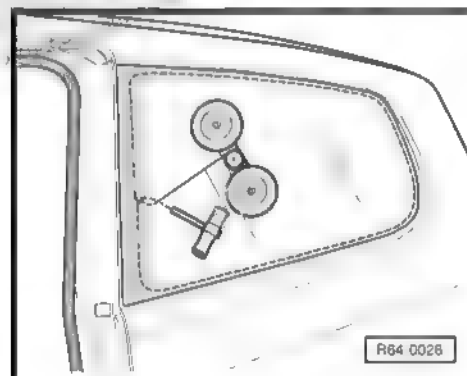
- Remove glass internal packing -1-



- Pull cutting wire - 357 853 999.A- with perforating tool - VAG 1474/2- (of -V.A.G 1474.B-) through adhesive card to vehicle interior.
- On areas with little clearance, you must distribute the cutting wire -357 853 999.A- on the outside and press under the lip with a plastic wedge .
- Place the cutting wire around the side glass.



- Pull external cutting wire end with a handle VAG 1351/1 using adhesive cord through vehicle interior.
- Fasten the other cutting wire edge in the device with ratchet - VAG 1654A- and cut glass adhesive. Change device with ratchet - VAG 1654A- position until complete adhesive cord cut.
- During the cutting (separation), press the cutting wire end against the glass with the plastic wedge to obtain free passage on the glass flange.



1.11 Damaged side glass (Fox - 2-door) - remove

Removal of damaged side glass is carried out the same way as described for rear glass removal ⇒ [page 152](#) .

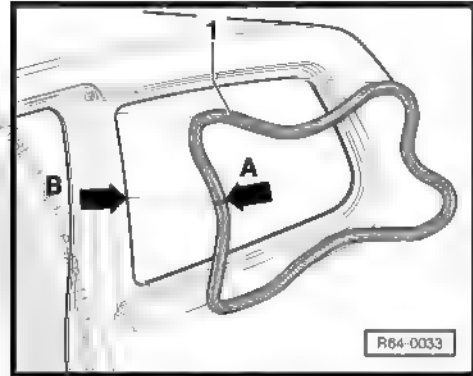
1.12 Side glass internal trim (Fox - 2-door) - install

When replacing packing, install the new part with a rubber hammer.

For partially removed packing, it is necessary to press packing sides before assembly.



- Install side glass internal packing -1- with centered vulcanized splice -arrow A- in window cut flange -arrow B-, and open over flange uniformly.



1.13 Side glass (Fox - 2-door) - install

When placing the side glass, you must maintain a 4.5 mm clearance between the upper glass corner and the glass flange on the side panel. That distance is occasionally necessary for main roof support fastening.

Prepare the undamaged glass to be installed ⇒ [page 156](#) .

Prepare the new glass to be installed ⇒ [page 157](#) .

Prepare the body flange for putting the glass ⇒ [page 158](#) .

Assembly instructions ⇒ [page 159](#) .

Minimum adhesive curing time ⇒ [page 160](#) .

1.14 Side glass (Spacefox) - assembly overview



1 - PUR adhesive bead

- ☐ Adhesive bead cross-section width 8...9 mm
- ☐ Adhesive bead cross-section height: 9...11 mm (including remaining material on glass and glass flange)
- ☐ Minimum curing time
⇒ [page 160](#)

2 - Side window

- ☐ Remove non-damaged side window
⇒ [page 149](#)
- ☐ Remove damaged side glass ⇒ [page 150](#)
- ☐ Install side glass
⇒ [page 150](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 143](#)

a = 3 mm

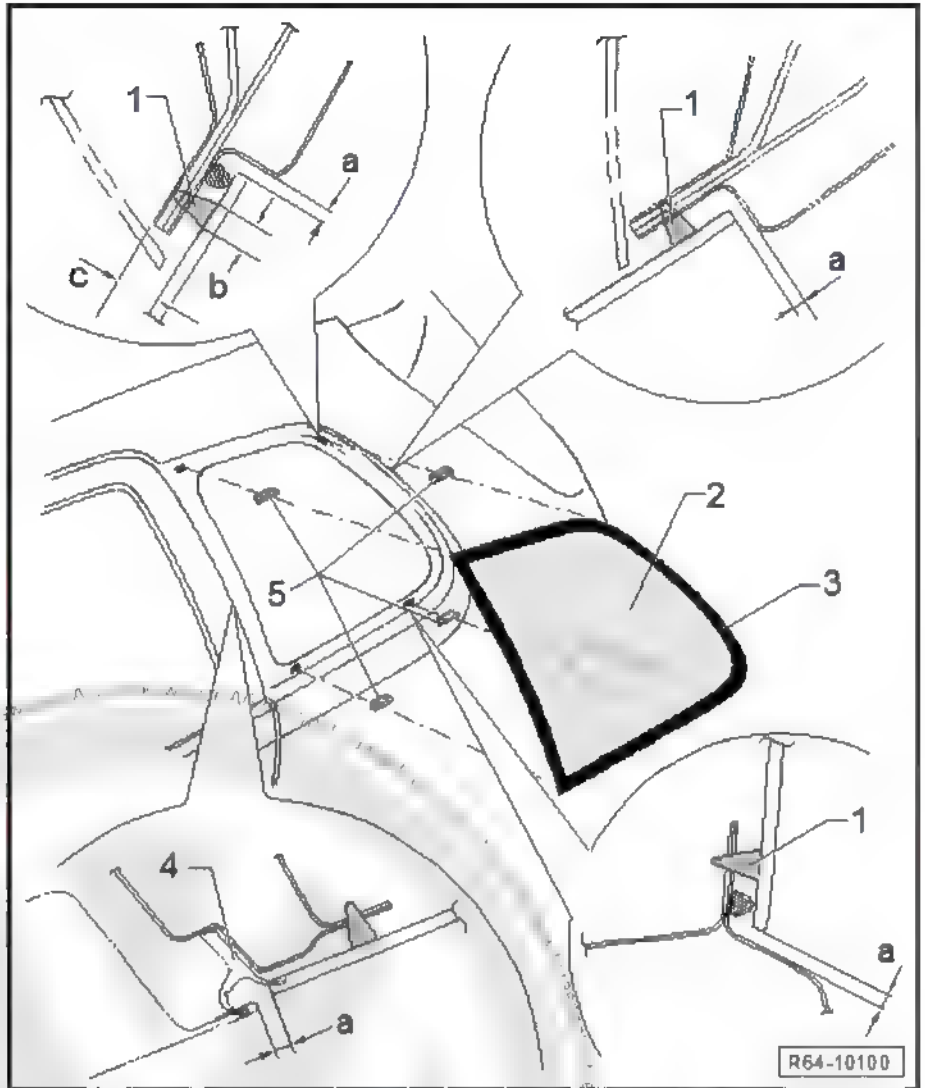
3 - PUR adhesive cord connection point

- ☐ PU adhesive application start and end.

4 - External door trim

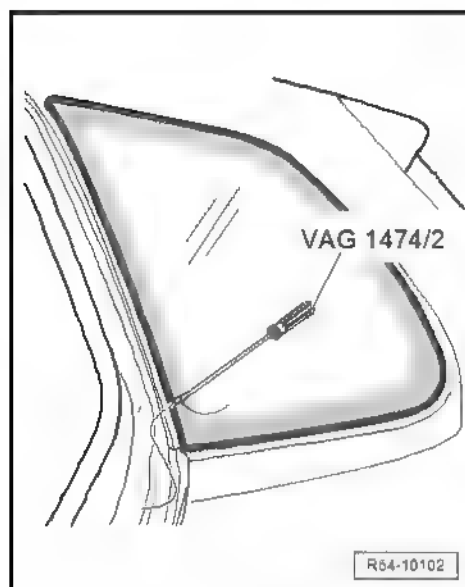
5 - Self-adhesive spacer shim

- ☐ 4 units
- ☐ adhesive spacer shim - 520 845 237-
- ☐ glue on body before installing the glass.

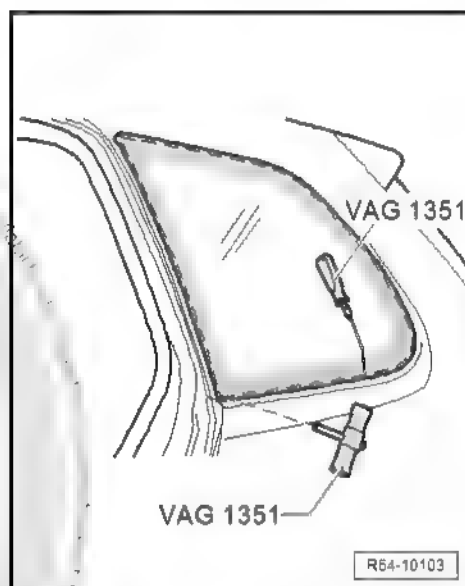


1.15 Undamaged side glass (Spacefox) - remove

- Remove the C and D-pillar coverings ⇒ General body repairs, interior, Rep. gr. 70 ; Lining / insulation .



- Insert the perforating tool - VAG 1474/2- between the glass and the glass frame, perforating the adhesive cord. Insert the cutting wire - 357 853 999 A- in the hole in the tool end, then pull the perforating tool - VAG 1474/2- and bring the wire to inside the vehicle.
- Fasten the cutting wire in the inner anchoring tool - VAG 1351/1, and the outer end with the traction cable - VAG 1351/1-.
- Traction the cutting wire through the traction cable - VAG 1351/1- and successively change the position of anchoring tool - VAG 1351- until cutting the adhesive completely.



1.16 Damaged side glass (Spacefox) - remove

Removal of damaged side glass is carried out the same way as described for rear glass removal ➔ [page 155](#).

1.17 Side glass (Spacefox) - install

When placing the side glass, you must maintain a 3 mm clearance between the upper glass corner and the glass flange on the side panel.

Prepare the undamaged glass to be installed ➔ [page 156](#).

Prepare the new window to be installed ➔ [page 157](#).

Prepare the body flange for putting the glass ➔ [page 158](#)

Assembly instructions ➔ [page 159](#)

Minimum adhesive curing time ➔ [page 160](#)

1.18 Rear window (Fox) - assembly overview



1 - Rear window

- ☐ Remove rear window
➔ [page 151](#)
- ☐ Install rear window
➔ [page 153](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only)
➔ [page 143](#)

2 - Defogger terminal

3 - Sealing

- ☐ for rear window wiper
- ☐ observe assembly position: rabbet facing upwards.

4 - PUR adhesive bead

- ☐ Cord cross-section -b- width: 6.. 7 mm
- ☐ Cord cross-section -c- height: 9...11 mm (including remaining material on glass and glass flange)
- ☐ Minimum adhesive curing time ➔ [page 160](#)

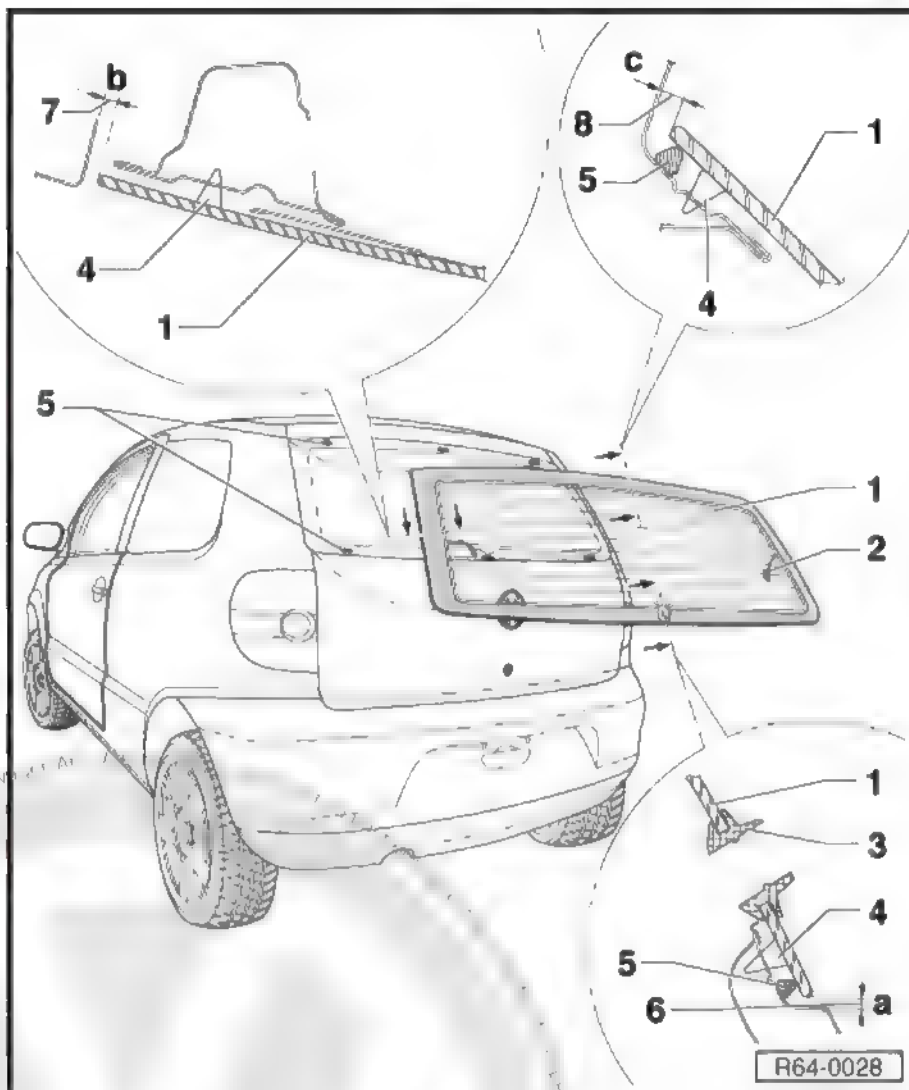
5 - Self-adhesive spacer shim

- ☐ 6 units
- ☐ self-adhesive
- ☐ glue on body before installing the glass.
- ☐ adhesive spacer shim - 620 845 237-

6 - Dimension a = 3 mm

7 - Dimension b = 4 mm

8 - Dimension c = 3 mm



1.19 Undamaged rear window (Fox) - remove

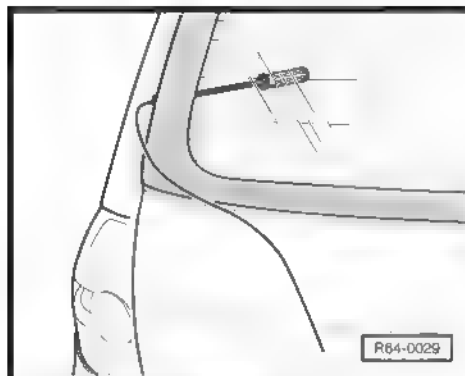
- Remove the rear door lining ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Disconnect rear glass defogger connections and press contact terminals on the glass.
- Remove the additional brake light ➔ Electrical system; Rep. gr. 94 ; Switches, lights and external lamps
- Remove the rear window wiper motor ➔ Electrical system, Rep. gr. 92 ; Windscreen, rear window and headlight wiper and washer
- If necessary, bend the handle (from - V.A.G 1474 B-) a little downwards to avoid too much tension on the rear window.



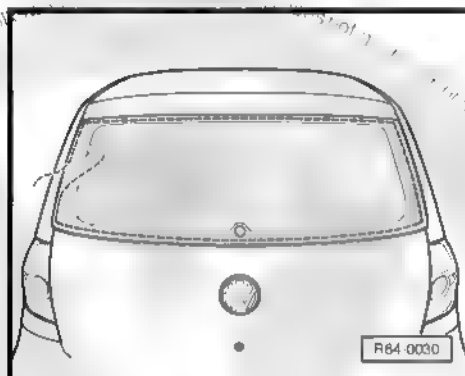
- Slightly open the lid and join the handle to the adhesive cord (use the rear window side area)

The handle must be guided as close as possible to the window.

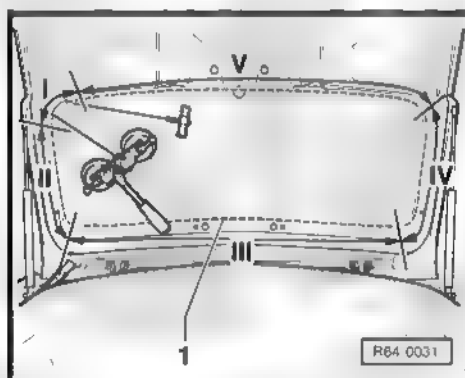
- Pull one end of the cutting wire inwards (use pliers and safety gloves)



- Place the cutting wire around the rear window.
- Pull the external end of the cutting wire inwards and fasten the handle to hold it.



- Mark the entire flange perimeter -1- with reinforced adhesive tape.
- Fasten the ends of the cutting wire to the device with ratchet - VAG 1654A-.
- Place the device with ratchet in "position I".
- Transfer the device with ratchet accordingly and cut (separate) the glass.
- During the cutting, press the cutting wire against the glass with the plastic wedge to obtain free passage on the glass flange.



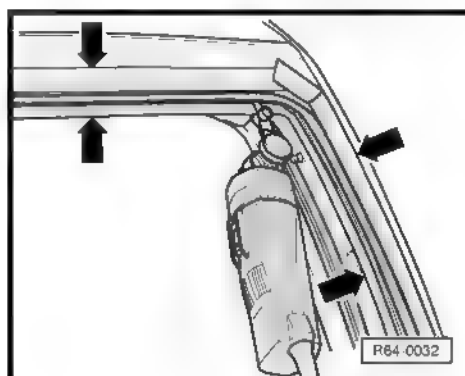
1.20 Damaged rear window (Fox) - remove

- Protect the body and the internal compartment from glass chips.
- Eliminate the glass chips until removing the adhesive sealing material.
- Disconnect glass defogger connections.
- Mark -arrows- the entire flange perimeter and the lid border with reinforced adhesive tape
- Cut the adhesive (with glass remains) at the glass cut with a blade - VAG 1561/10- (with limiter roll)



DANGER!

It is mandatory to wear safety goggles and safety gloves.



1.21 Rear window - install

Prepare the undamaged glass to be installed ➤ [page 156](#)

Prepare the new glass to be installed ➤ [page 157](#).

Prepare the body flange for putting the glass ➤ [page 158](#).

Assembly instructions ➤ [page 159](#).

Minimum curing time ➤ [page 160](#).

1.22 Rear glass (Spacefox) - assembly overview

1 - Rear window

- ☐ Remove non-damaged rear window ➤ [page 153](#)
- ☐ Remove damaged rear window ➤ [page 155](#)
- ☐ Install rear window ➤ [page 153](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only) ➤ [page 143](#)

a = 3 mm

2 - Sealing

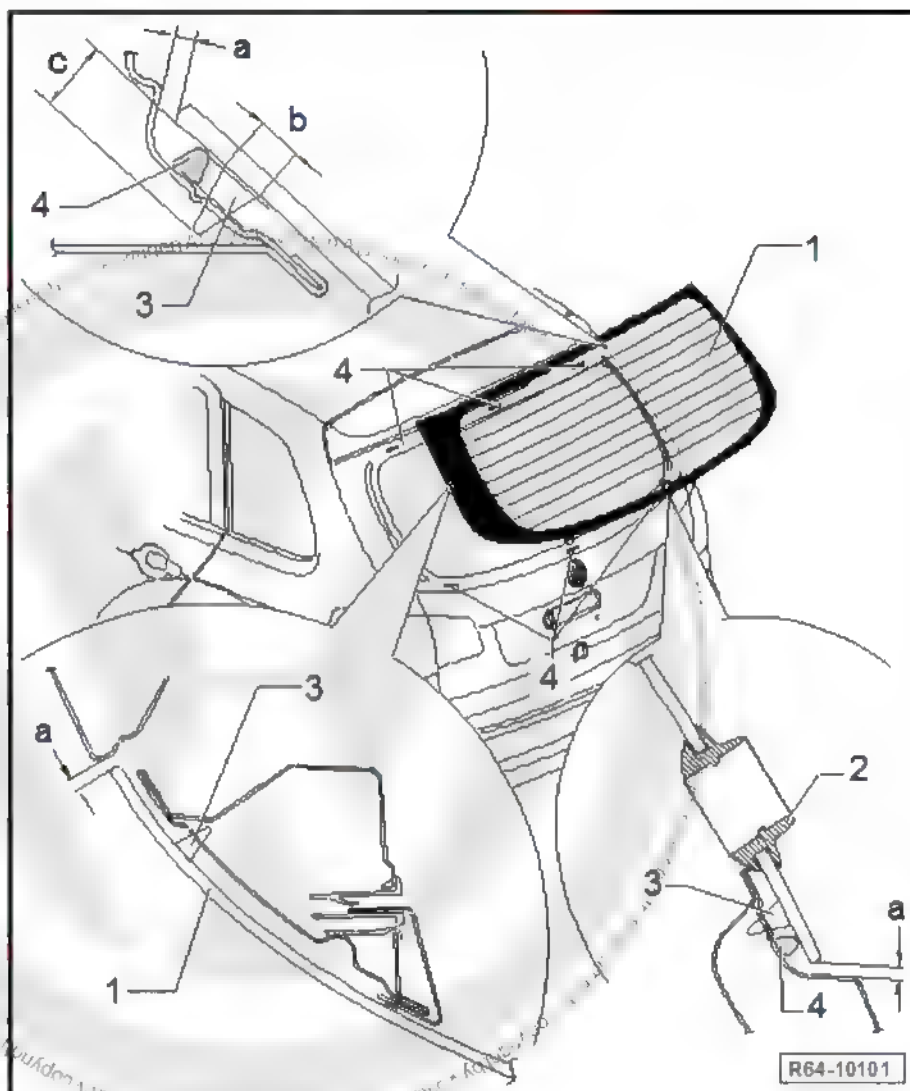
- ☐ for rear window wiper
- ☐ observe assembly position: rabbit facing upwards.

3 - PUR adhesive bead

- ☐ Cord cross-section -b- width: 6.7 mm
- ☐ Cord cross-section -c- height: 9.11 mm (including remaining material on glass and glass flange)
- ☐ Minimum adhesive curing time ➤ [page 160](#)

4 - Self-adhesive spacer shim

- ☐ 6 units
- ☐ self-adhesive
- ☐ glue on body before installing the glass.
- ☐ adhesive spacer shim - 5Z0 845 237-

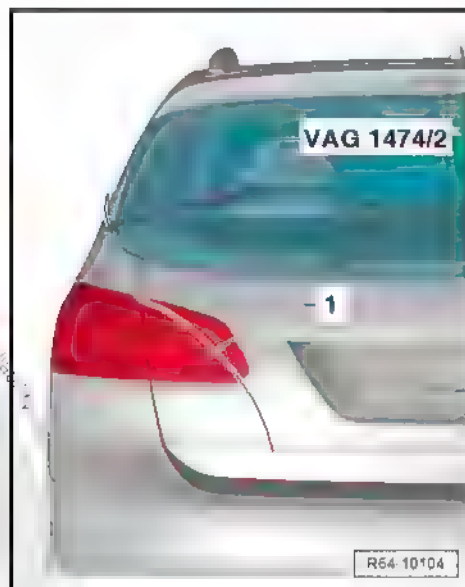


1.23 Undamaged rear window (Spacefox) - remove

- Remove the rear door lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Disconnect rear glass defogger connections and press contact terminals on the glass.



- Remove the additional brake light ➔ Electrical system; Rep. gr. 94 ; Switches, lights and external lamps
- Remove the rear window wiper motor ➔ Electrical system; Rep. gr. 92 ; Windscreen, rear window and headlight wiper and washer



Insert the perforating tool - VAG 1474/2- between the glass and the glass frame, perforating the adhesive cord. Insert the cutting wire - 357 853 999 A- in the hole in the tool end, then pull the perforating tool - VAG 1474/2- and bring the wire to inside the vehicle.

- Encircle the entire glass with the cutting wire - 357 853 999 A- .





- Fasten the cutting wire inside the vehicle in the anchoring tool - VAG 1654A-, and the outer end with the traction cable - VAG 1351/1-.
- Place the device with ratchet - VAG 1654A- in "position I", and traction the wire.
- Transfer the device with ratchet - VAG 1654A- to "position II" as the adhesive gets cut.
- During cutting, press the cutting wire -357 853 999.A- against the glass with the plastic wedge -VAG 1474/5- to obtain free passage on the glass flange.
- Traction the cutting wire through the traction cable - VAG 1351/1- and successively change the position of anchoring tool - VAG 1351- until cutting the adhesive completely.
- Remove the glass with the suction pads - V.A.G 1344-.

1.24 Damaged rear window (Spacefox) - remove

Prepare the undamaged glass to be installed ➔ [page 156](#)

Prepare the new glass to be installed ➔ [page 157](#)

Prepare the body flange for putting the glass ➔ [page 158](#).



Assembly instructions ➤ [page 159](#) .

Minimum curing time ➤ [page 160](#) .

1.25 Undamaged glass - prepare for install



WARNING

- ◆ When handling chemicals follow the safety instructions ➤ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ➤ *Electronic Parts Catalogue "ETKA"*

For the export market



WARNING

*Do not apply under PU bead recently cut with the activator.
Keep the adhesion surface clean and free from grease.*



Note

- ◆ When reusing undamaged glass, reduce the adhesive cord layer to between 1 and 2 mm of height and do not damage the primer and ceramic coats.
- ◆ The adhesive bead layer works as a base for the new adhesive bead.



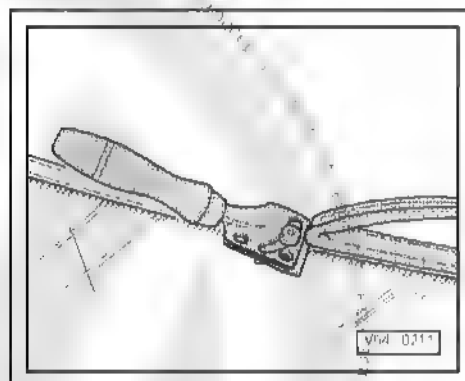
WARNING

Exception: If the adhesion process is conducted more than one day after the reduction of adhesive layer, then the latter must be activated with the activator - D 181 802 M1- , using the applicator - D 009 500 25-

Apply the activator evenly.

The activator must not touch the painted surface, as it will result in damage to the latter.

The drying time is approximately 10 minutes.



For the Brazilian market



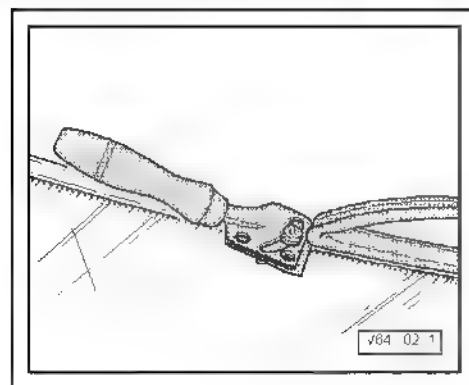
WARNING

Clean the adhesion bead area with the cleaning solution - D 009 401 04- .



Note

- ◆ When reusing undamaged glass, reduce the adhesive cord layer to between 1 and 2 mm of height and do not damage the primer and ceramic coats.
- ◆ The adhesive bead layer works as a base for the new adhesive bead.



1.26 New glass - prepare for install



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

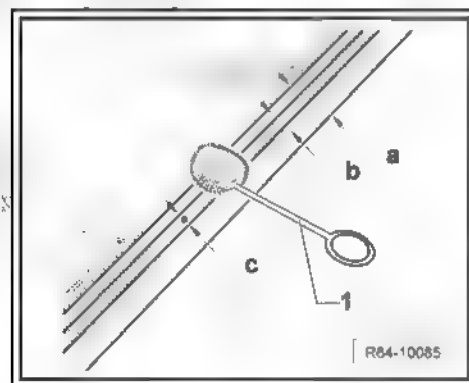
- Install two suction pads - V.A.G 1344- for glass handling.
- Clean the glass edge throughout about 25 mm of its -area- with the cleaning solution -D 009 401 04-.



Note

For vehicles in the Brazilian market, use primers from the glass gluing kit.

- Rub the glass edge dry with a clean cloth.
- ◆ a = area with ceramic paintwork.
- ◆ b = area for application of the primer.
- ◆ c = area for application of the PU adhesive.

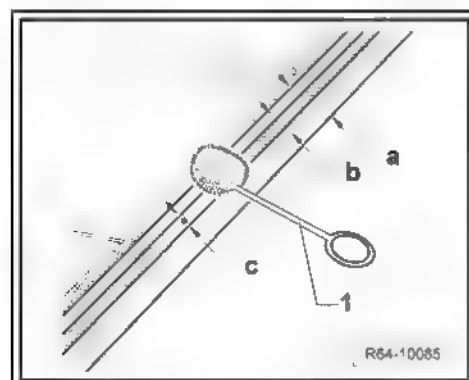


- Apply, on area -b-, the primer - D 009 200 02- with the applicator - D 009 500 25- -1- (felt sphere with wire) on area -b- of the window only. The drying time of the primer is 15 minutes.
- ◆ b = 12 ± 0.04 in



Note

- ◆ After applying the primer, the surface cannot be touched under any circumstances
- ◆ The area -c- is reserved for applying the adhesive bead





1.27 Body flange - prepare to install the window



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

For the export market



WARNING

Do not apply primers to the adhesion surface. Keep the adhesion surface free from dirt and grease.

Do not apply to the surface of the adhesive recently cut with the activator.

- Cut body flange adhesive excess with a 15-mm Blade - VAG 1561/8- , and never completely remove the adhesive under any circumstances.



Note

Old adhesive layer works as anchoring for the new cord. Adhesive application areas should be thoroughly free from dirt or oiliness.

- ◆ If the body flange has been repainted, the corresponding area shall be cleaned once more, and the primer must be applied - D 009 200 02- with the applicator - D 009 500 25- .



WARNING

Exception: If the adhesion process occurs more than one day after the adhesive bead is cut, the layer must be activated with the activator - D 181 802 M1- .

The activator must be evenly applied using the applicator.

The activator must not touch the painted surface, as it will result in damage to the latter.

The drying time of the activator is approximately 10 minutes.

- Glue the self-gluing buffer spacers - 5Z0 845 237- to the flange of the window frame.

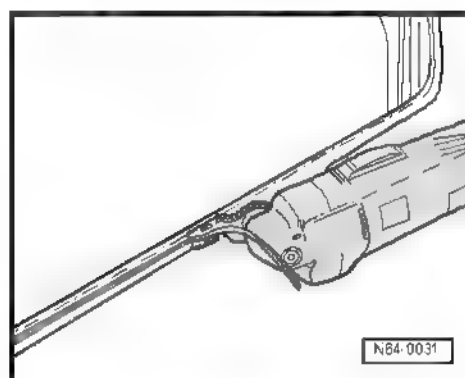
For the Brazilian market



WARNING

Clean the entire body flange with the cleaning solution - D 009 401 04- .

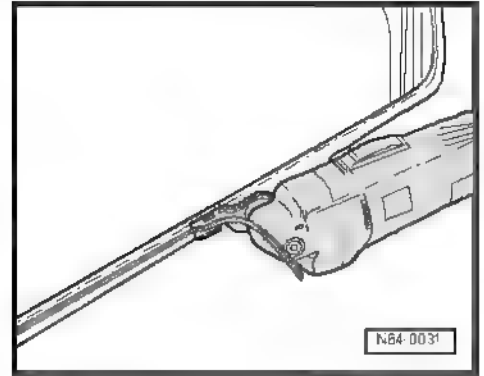
- Cut body flange adhesive bead excess with a 15-mm Blade - VAG 1561/8- . Maintain a layer with 1 mm of thickness.





Note

- ◆ *Old adhesive layer works as anchoring for the new cord. Adhesive application areas should be thoroughly free from dirt or oiliness.*
- ◆ *If flange has been repainted, apply the primer - 5404 A- ➔ [page 143](#) with the applicator - D 009 500 25-.*
- ◆ *Glue the self-gluing buffer spacers - 5Z0 845 237- to the flange of the window frame.*

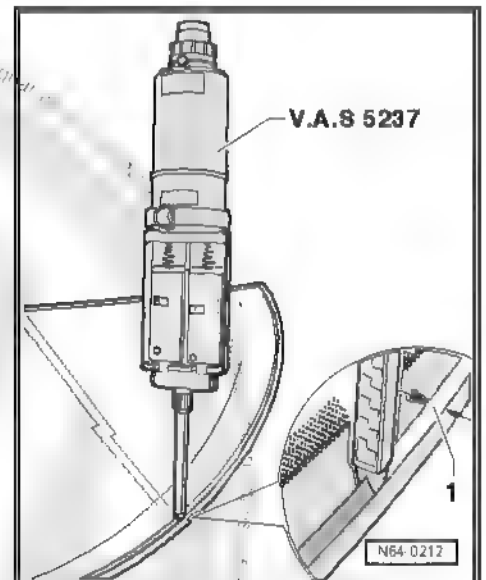


1.28 Assembly instructions



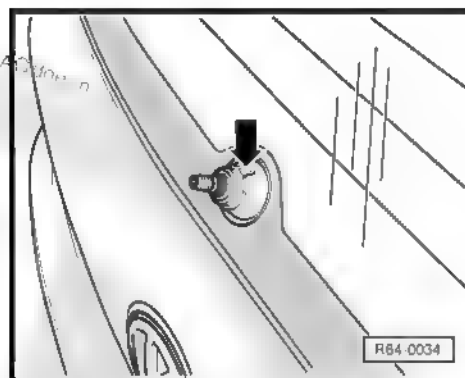
DANGER!

The glass must be placed within 10 minutes, otherwise its adhesion will be compromised.





- ◆ Place the glass on the body frame using two suction pad grippers - V.A.G 1344- , align and press inwards the spacer on the side glass packing (side glass).
- ◆ Apply the adhesive throughout the contour and at a straight angle in relation to the window.
- ◆ The beginning and end of the application of the adhesive PU, DA 004 600 A2 or DH 009 100 (see correspondence table → [page 143](#)) must coincide with the lower center of the glass.
- ◆ Windscreen clearance dimensions → [page 143](#) .
- ◆ Fasten the windscreen during curing time with the windscreen shims -443 845 631 A- .
- ◆ The lower windscreen covering must be mandatorily installed as described in .
- ◆ If there were warning tags originally installed (for example, for Airbag), they must be re-installed.
- ◆ Side glass clearance dimensions → [page 145](#) .
- ◆ When placing the side glass, you must maintain a 4.5 mm clearance between the upper glass corner and the glass flange on the side panel.
- ◆ When placing the sealing packing for the rear window wiper motor shaft, follow the assembly position. The marking -arrow- points upwards.
- ◆ Clearance dimensions for rear glass → [page 150](#) .
- ◆ The primer cannot be applied over the defogger fillets.
- ◆ There are markings on the right and left sides of the rear window for adhesive application.
- ◆ Fasten the rear window with adhesive tape during the curing time.
- ◆ If adhesive cord is applied out of specified dimensions, it may spread over defogging filaments. In this condition, adhesive must be removed.



Note

- ◆ Check for water infiltration by hosing (without pressure) the external surface of the vehicle. Carefully observe the inside of the vehicle.
- ◆ Etch the VIS number on the replacement windows (Brazil only → [page 143](#)), material to be used, → Chemical Material Manual; Rep. gr. 00; Chemical Material Manual - List of authorized products .

1.29 Minimum adhesive drying time



WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"



Note

- ◆ *In the event windows are to be replaced, certain requirements must be fulfilled in order to abide by the operational safety norms, even in the event of accidents.*
- ◆ *The vehicle may be delivered to the client 3 hours after repair. Inform the client of the precautions to be taken during the total adhesive drying time.*
- ◆ *The adhesive reacts with air humidity. The infiltration test accelerates the drying process of the adhesive*

Type of glass	Vehicle	Window adhesive	Minimum drying time	Total drying time
Windscreen	With and without airbag	DH 009 100 or U 400 HV	3 hours	72 hours
Side and rear windows				

During this time, the vehicle must remain on a flat surface and at room temperature (at least 59 °F).



DANGER!

The vehicle can only be delivered to the client after the minimum drying time because the safety requirements will only be fulfilled after this time.

1.30 Paint damage - repair



WARNING:

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Repaint following the procedures described in ⇒ Paint Manual - Paint repair in on steel plates and zinc-coated steel plates .

If damages to paint occur in areas which are not visible from outside, apply body primer - D 009 200 02-



Note

- ◆ *Minimum drying time of 10 minutes*
- ◆ *Only if the damage is located in the area covered by the component, otherwise the part must be repainted*



1.31 Cleaning in case of resulting adhesive residues



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- We recommend, as cleaning product, the use of adhesive remover - D 002 000 10- . Follow the safety rules during the application.



DANGER!

When cleaning from the vehicle cabin, do not press inside out a glass that has just been placed (cured adhesive).

- First, clean the painted surface with a dry cloth. Eliminate dirt remains with the adhesive remover - D 002 000 10- .
- Clean the plastic coating: Let the polyurethane adhesive dry (approximately 1 hour), then remove it.



2 Tilting window

2.1 Tilting window (Fox - 2-door) - remove and install

1 - Tilting window

- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 143](#)
- ☐ Remove:
 - Remove B-pillar linings
⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations
 - Open window and remove adjustment screw
⇒ [Item 4 \(page 163\)](#) .
 - Remove hexagonal nuts
⇒ [Item 11 \(page 163\)](#) , then remove glass.
- ☐ Adjust ⇒ [page 164](#)

2 - Glass internal packing

- ☐ fitted to the fitting flange
- ☐ Install packing
⇒ [page 164](#)

3 - Dimension a = 3.5 mm

4 - Setscrew

- ☐ Torque: 5 Nm

5 - Retaining nut

6 - Bolt

- ☐ Torque: 5 Nm

7 - Fastening

8 - Bolt

- ☐ Torque: 8 Nm

9 - Mounting bracket

- ☐ After removing or loosen support, adjust tilting window ⇒ [page 164](#)
- ☐ For removal, remove C-pillar lining → General body repairs, interior; Rep. gr. 70 ; Linings / insulations

10 - Dimension b = 3.5 mm

11 - Hexagonal nut

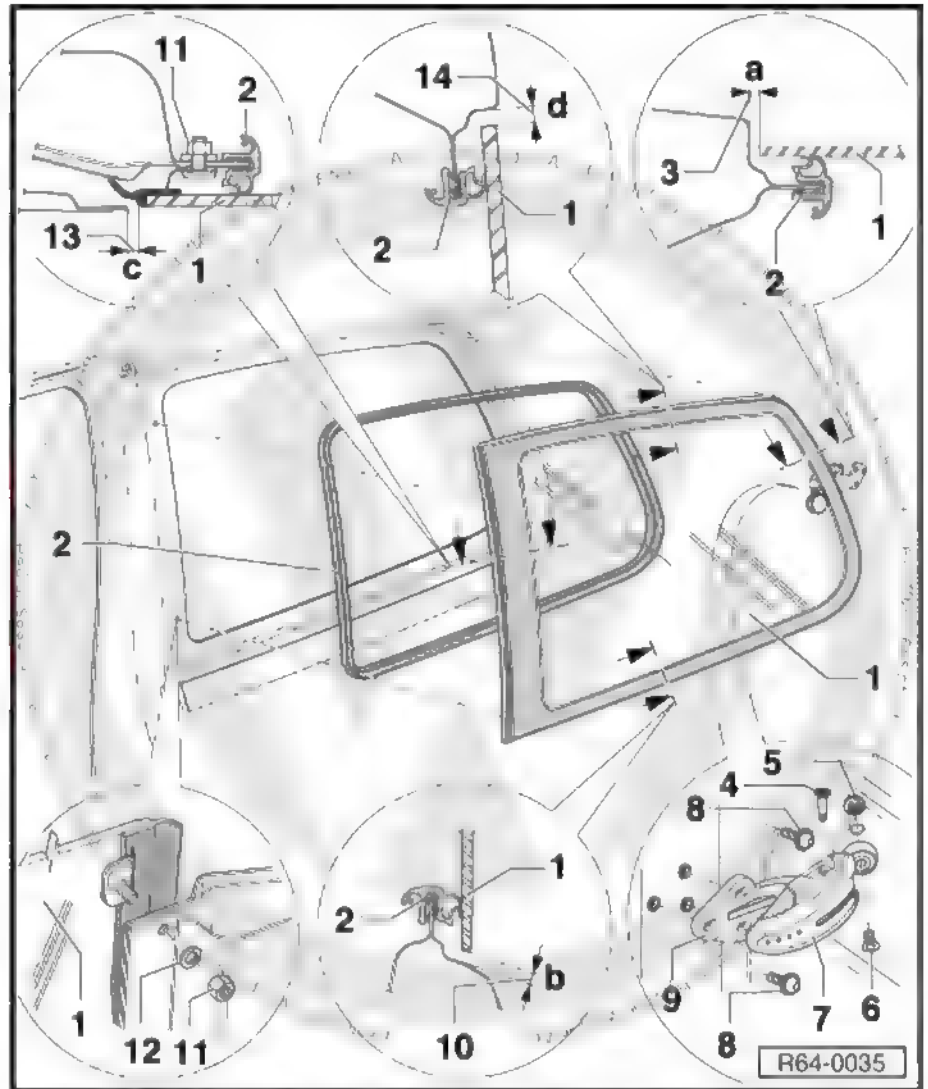
- ☐ Torque: 8 Nm

12 - Washer

13 - Dimension c = 3 mm

14 - Dimension d = 4.5 mm

- ☐ Clearance dimension must be followed, as the distance is necessary for main roof support fastening





2.2 Glass internal packing - install

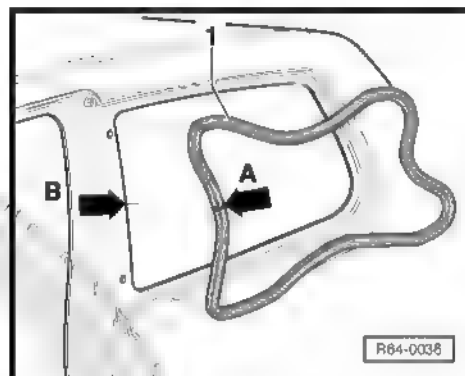
The side glass internal packing receives a standard sealing application when fitted to the window flange.

When removed, part of the sealing putty is in packing, and the and other part is in the fitting flange. Sealing problems may occur if sealing is re-installed.

When replacing packing, install the new part with a rubber hammer.

For partially removed packing, it is necessary to press packing sides before assembly.

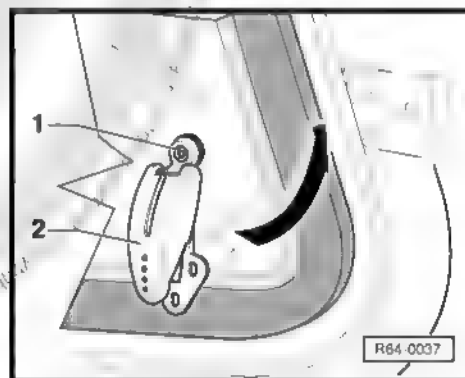
- Install side glass internal packing -1- with centered vulcanized splice -arrow A- in window cut flange -arrow B-, and open it uniformly over the flange.



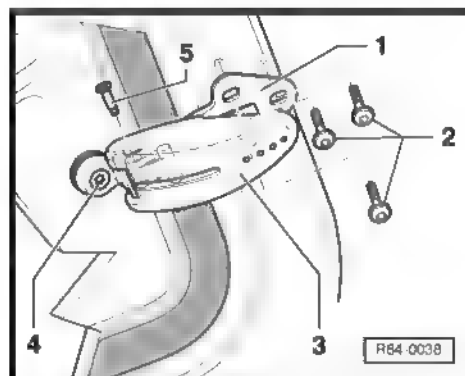
2.3 Tilting window - adjust

Tilting window adjustment is necessary if a new window is installed or window opening lever is loosen from pillar C or from the glass.

- Remove the C-pillar lining ⇒ General body repairs, interior; Rep. gr. 70 ; Linings/insulation
- Fasten tilting window on pillar B ⇒ [Item 11 \(page 163\)](#) .
- If necessary, loosen screw -1-, turn opening lever -2- until installation position -arrow- and tighten screw -1- (4 Nm).



- Assemble the support -1- on pillar C with screws -2-, and close the window.
- Loosen screw -4- approx. 2 turns (until free passage is noticed)
- Press the tilting window over internal packing from outside (2° assembler) and tighten screws -2- (8 Nm) and -4- (5 Nm).
- To assemble C-pillar lining or disassemble the tilting window after adjustment is carried out, just unscrew adjustment screw -5- (4 Nm) and separate support -1- and fastening -3-.





3 Door window glass

3.1 Front door window glass - assembly overview

1 - Door window glass

- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 143](#)
- ☐ Remove and install
⇒ [page 165](#)

2 - Door window external trim

- ☐ fitted onto flange

3 - Door groove

- ☐ fitted onto flange

4 - Door window internal trim

- ☐ fitted onto flange

5 - Door

6 - Window drive mechanism

- ☐ Remove and install
⇒ [page 169](#)

7 - Power window drive mechanism

- ☐ Remove and install
⇒ [page 169](#)

8 - Washer

- ☐ 5 units

9 - Pop rivet

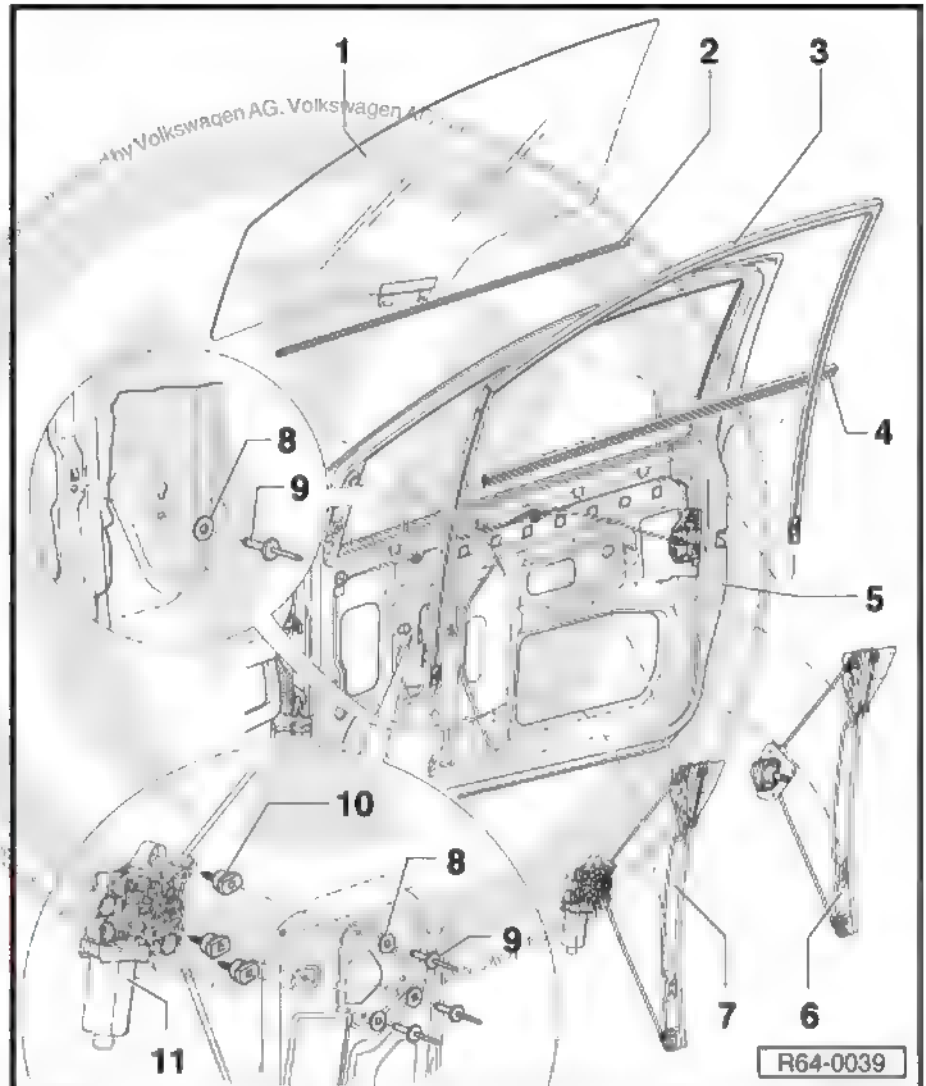
- ☐ 5 units
- ☐ drill rivet for disassembly

10 - Pad

- ☐ Torque: 3.5 Nm
- ☐ 3 units
- ☐ replace whenever mechanism -6 -or -7- is removed.

11 - Window drive motor

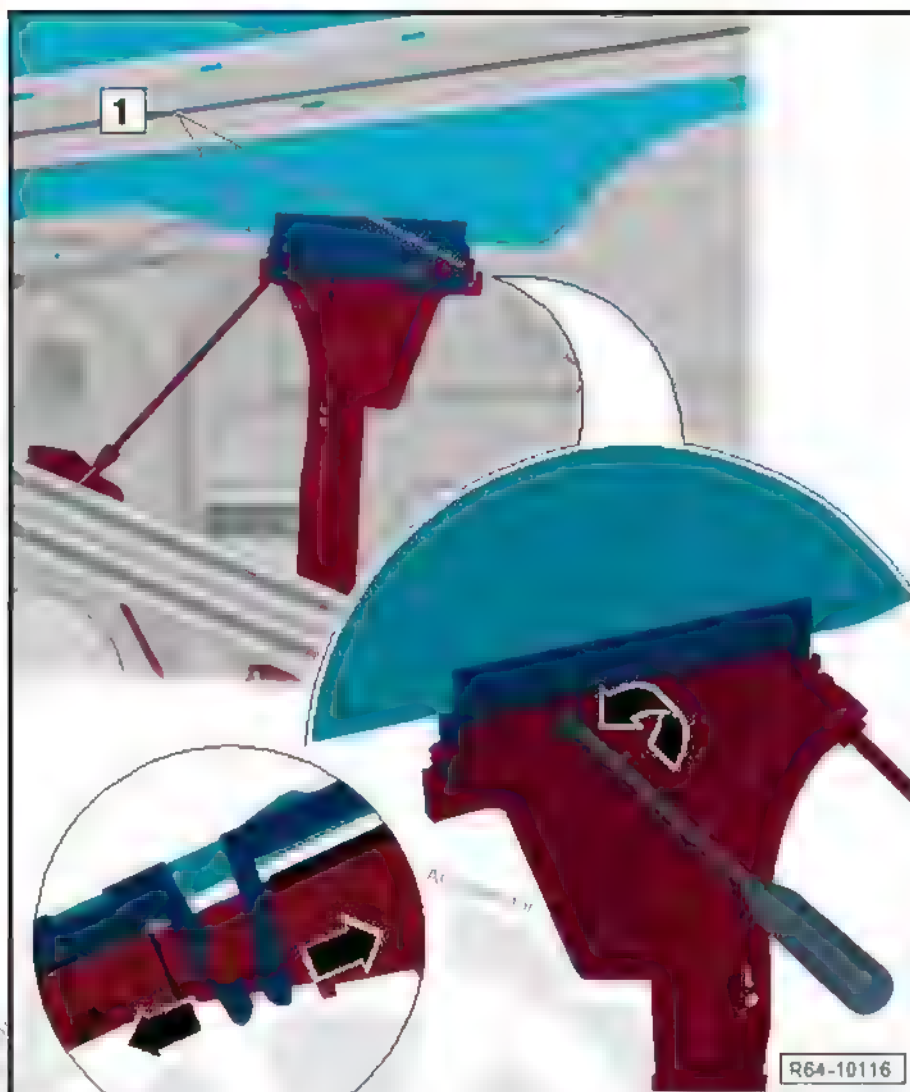
- ☐ Remove and install ⇒ [page 171](#)



3.2 Front door window glass - remove and install

Remove

- Remove the front door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Remove sealing membrane.
- Lower door window glass until the support is accessible on the window activation mechanism.

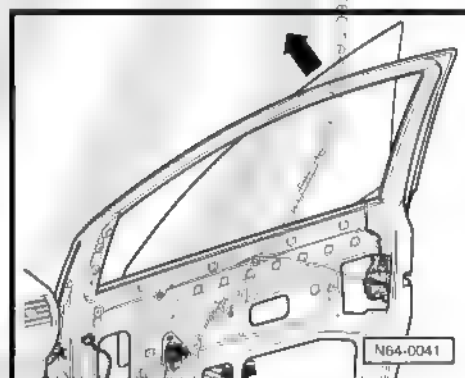


- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Lift the door window glass from behind, turn outside the door forward and, towards -arrow-, forwards.

Install

Installation is performed in the reverse sequence; in this case, observe the following:

- After assembling the door window glass, you must check the operation of the window drive mechanism.





3.3 Convenience system window drive mechanism (automatic window closing and opening mechanism) with force limiter (anti-crushing function)

The front window drive mechanisms are additionally equipped with the automatic window closing and opening mechanism for the vehicles with convenience system

The automatic window opening and closing switches for the front window are located at the driver's door control. The switches for the passenger's door are equipped with a two-level function.

If the respective switch is pushed or pulled up to the first level, the front window opens or closes manually.

If the switch is completely pushed or pulled up to the second level, the window will open or close automatically.

Additionally, on the passenger's door there is an additional switch for the passenger's door window.

All power drive mechanisms are equipped with a force limiter (anti-crushing device). The window closing is automatically interrupted when an obstacle blocks the closing route.

However, that is not valid for window closing determined from the outside, with the ignition key. In this case, there is no force limitation.

3.3.1 Operation of the window drive mechanism with the ignition turned on

Opening

Switch on the driver's door

- Press the switch up to the first level. The window glass is opened while the switch is pressed down or when the final position is reached.
- Briefly press the switch down to the second level. The window glass opens automatically (automatic lowering).
- If the switch is operated again, the window glass will stop immediately.

Switch on the passenger's door

- Press the lower switch surface. The window glass is opened while the switch is pressed down or when the final position is reached.

Closing

Switch on the driver's door

- Pull switch up to the first level. The window glass is closed while the switch is pulled or when the final position is reached
- Briefly pull the switch up to the second level. The window glass closes automatically (automatic closing)
- If the switch is operated again, the window glass will stop immediately.

Switch on the passenger's door

- Press the upper switch surface. The window glass is closed while the switch is pressed down or when the final position is reached.



3.3.2 Operation of the window drive mechanism with the ignition turned off

The window drive mechanisms can still be operated for approx 10 minutes after the ignition is turned off, while the driver's or the passenger's door is not opened.

For window closing, there is no automatic closing function available

If the driver's or the passenger's door window cannot be closed due to mobility problems or the presence of an obstacle to the closing (force limiter), the window glass immediately opens.

In this case, the window glass can only be closed again if the ignition is turned on.

The window glasses can still be opened or closed from the outside in vehicles with central locking. For this purpose, the key only needs to be pressed in the closing or opening position.

3.3.3 Actuation of automatic window closing and opening mechanism



Note

After disconnecting / connecting the battery of the vehicle or after some actuations of the force limiter function, the automatic door window closing and opening mechanism will be disabled.

For enabling this function, we should follow the procedure below:

- Press the key until fully closing the window glass and keep it pressed for a few seconds. Repeat this operation for the other door window glass keys that have this function disabled.

By pressing or pulling a button until the first level, the window opens or closes while the button is being activated.

The door window glass opens automatically (automatic opening) or closes automatically (automatic closing) whenever pressing or pulling the key briefly.

The glass will stop at the current position if the key is pressed while the door window glass opens or closes.

After turning the ignition off, there is no one-touch window opening and closing function, even when the key is still inserted in the ignition cylinder

3.3.4 Force limiter function (anti-crushing device)

- Condition: Automatic window glass closing and opening function disabled
- Ignition key inserted in the ignition cylinder and ignition on.
- Close the door window glass with the window drive switch (automatic closing)



Note

The door window will stop and the glass will move backward some centimetres if the door window does not close due to an obstacle (force limiter was activated).



- Ignition key inserted in the door lock cylinder or the remote control is actuated through the outer portion of the vehicle
- Turn the door lock cylinder with the ignition key in the closing direction or actuating the remote control in the locking direction.



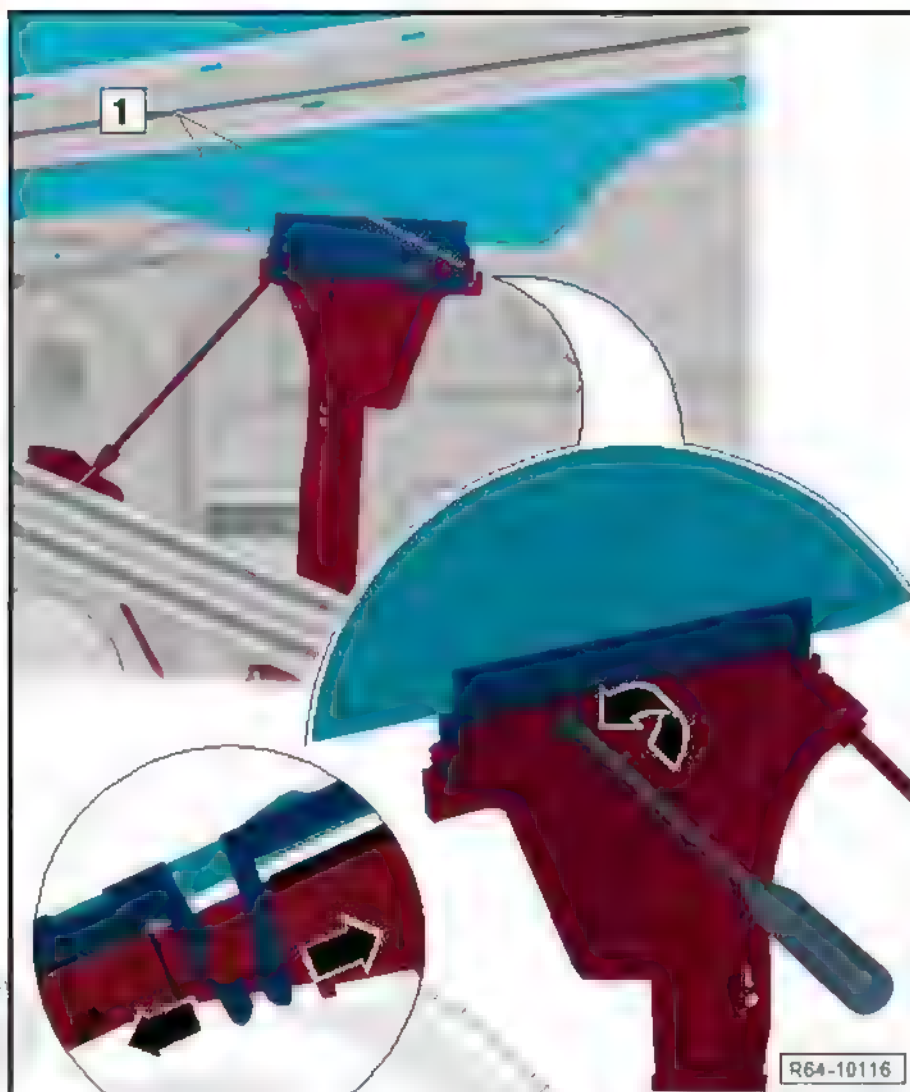
Note

The door window will stop and the window, will move backward some centimetres if the door window does not close due to an obstacle (force limiter was activated). The alarm horn emits three sound warnings "Beeps" and the "LED" of the alarm system remains constantly lighted up in the door locking pin frame.

3.4 Window drive mechanism - remove and install

Remove

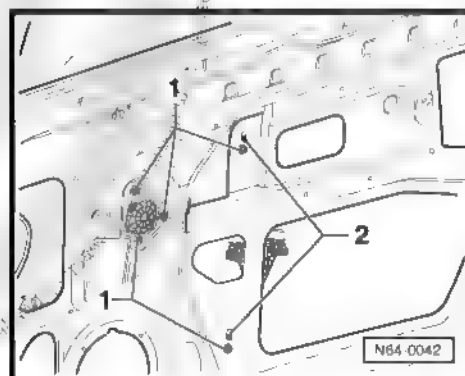
- Remove the front door lining = General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Remove sealing membrane.
- Lower door window glass until the support is accessible on the window activation mechanism.



- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Push the door's window glass up and immobilize it.
- Through the assembly opening, disconnect window activation motor of the window power activation mechanism.
- Drill pop rivets -1-, lift the window activation mechanism from the couplings -2- and remove downward out through the assembly opening.

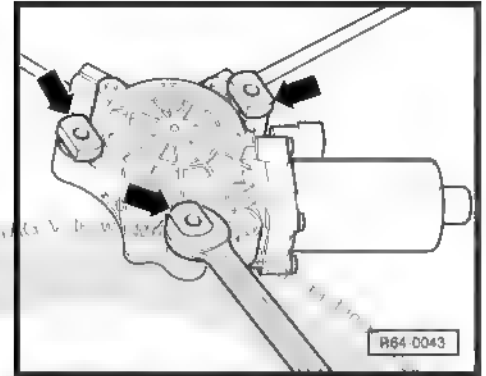
Install

Install is performed in the reverse sequence, observing the following:





- Replace the mountings -arrows-. Fasten new mounting to 3.5 Nm.
- Fasten glass activation mechanism to door with pop rivets; do not forget washers in this case.
- After assembling the door window glass, you must check the operation of the window drive mechanism.



3.5 Window drive motor - remove and install

Remove

- Remove window activation mechanism ➔ [page 169](#).
- Unscrew fastening screws -arrows-.
- Remove motor -1- from glass activation -2-.

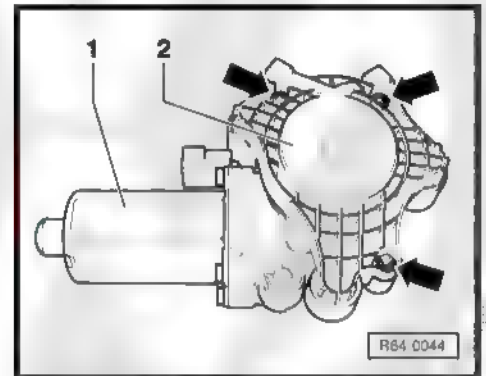
Install

Installation is performed in the reverse sequence; in this case, observe the following:

- Tighten fastening screws with:

Torque: 3.5 Nm

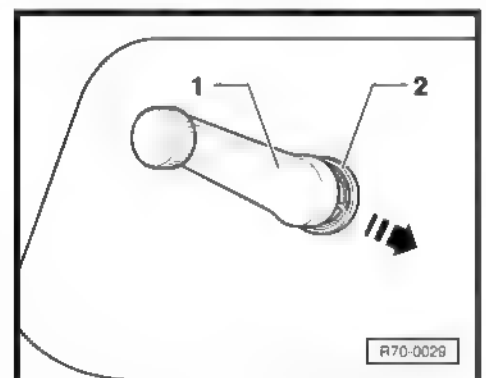
- Before installing the window drive mechanism, you must check its operation.



3.6 Front door window crank - remove and install

3.6.1 Remove

- With the door window fully closed, move the crank spacer in the indicated direction.
- Disengage the crank and remove it.

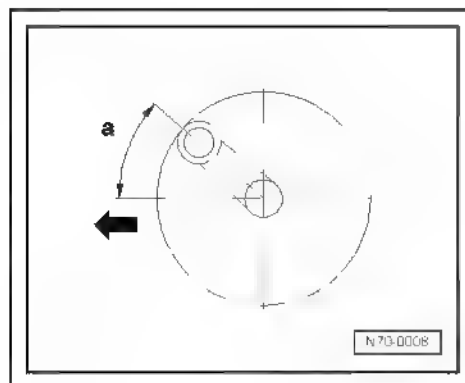


3.6.2 Install

- Installation is performed in the reverse sequence to the removal, considering the following:



- Position the crank at 45° in the indicated direction and fit the spacer.
- After assembling the door window glass, check the operation of the window activation mechanism. The "arrow" in the Figure points in the travel direction.



3.7 Front door window channel - remove and install

3.7.1 Remove

- Remove the door window ⇒ [page 165](#) .
- Carefully disengage and remove the channel.

3.7.2 Install

- Installation is performed in the reverse sequence to the removal.

3.8 Front door window internal trim - remove and install

3.8.1 Remove

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the trim by disengaging it from the door.

3.8.2 Install

- Installation is performed in the reverse sequence to the removal.

3.9 Front door window external trim - replace

3.9.1 Remove

- Disengage trim and remove it.

3.9.2 Install

- Installation is performed in the reverse sequence to the removal.

3.10 Rear door window glass - assembly overview



1 - Door window glass

- ☐ Label request for engraving the VIS number on windows (Brazil only) ➤ [page 143](#)
- ☐ Remove and install ➤ [page 174](#) .

2 - Door window fixed glass

- ☐ Remove ➤ [page 178](#) .

3 - Rear chute

4 - Insert

5 - Rear guide rail

- ☐ Remove and install ➤ [page 177](#)

6 - Bolt

- ☐ Torque: 5.5 Nm

7 - Plug

8 - Door

9 - Window drive mechanism

- ☐ Remove and install ➤ [page 177](#) .

10 - Power window drive mechanism

- ☐ Remove and install ➤ [page 176](#) .

11 - Pop Rivet

- ☐ 5 units
- ☐ Drill rivet for disassembly

12 - Washer

- ☐ 5 units

13 - Pad

- ☐ Torque: 3.5 Nm
- ☐ 3 units
- ☐ replace whenever mechanism -9- or -10- is removed.

14 - Window drive motor

- ☐ Remove and install ➤ [page 176](#)

15 - Bolt

16 - Internal trim

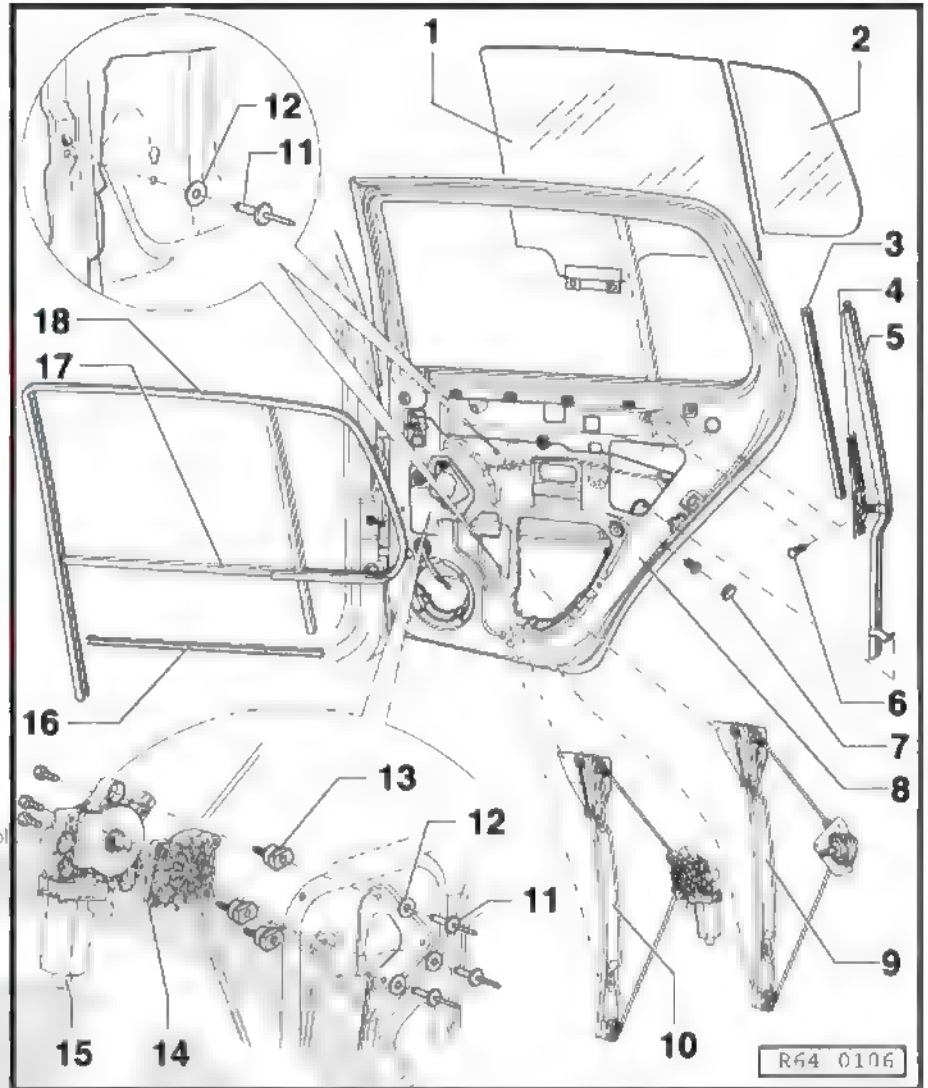
- ☐ Remove and install ➤ [page 178](#)

17 - External trim

- ☐ Remove and install ➤ [page 178](#)

18 - Chute

- ☐ Remove and install ➤ [page 178](#)





3.11 Rear door window glass - remove and install

3.11.1 Remove

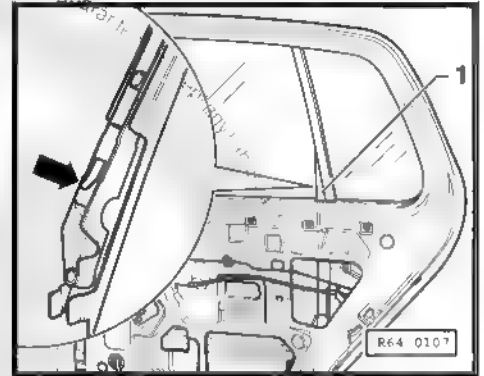
- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Lower the door window glass until its support is accessible.
- Remove sealing membrane.
- Lower door window glass until the support is accessible on the window activation mechanism.



- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Remove upper screw from rear guide rail.
- Remove internal packing from door.



- Unlock groove upward in rear guide rail section.
- Move thread -1- by pushing it upward until its lock "arrow" is released
- Remove thread.
- Then, lift door window glass carefully removing it from the door internal side.



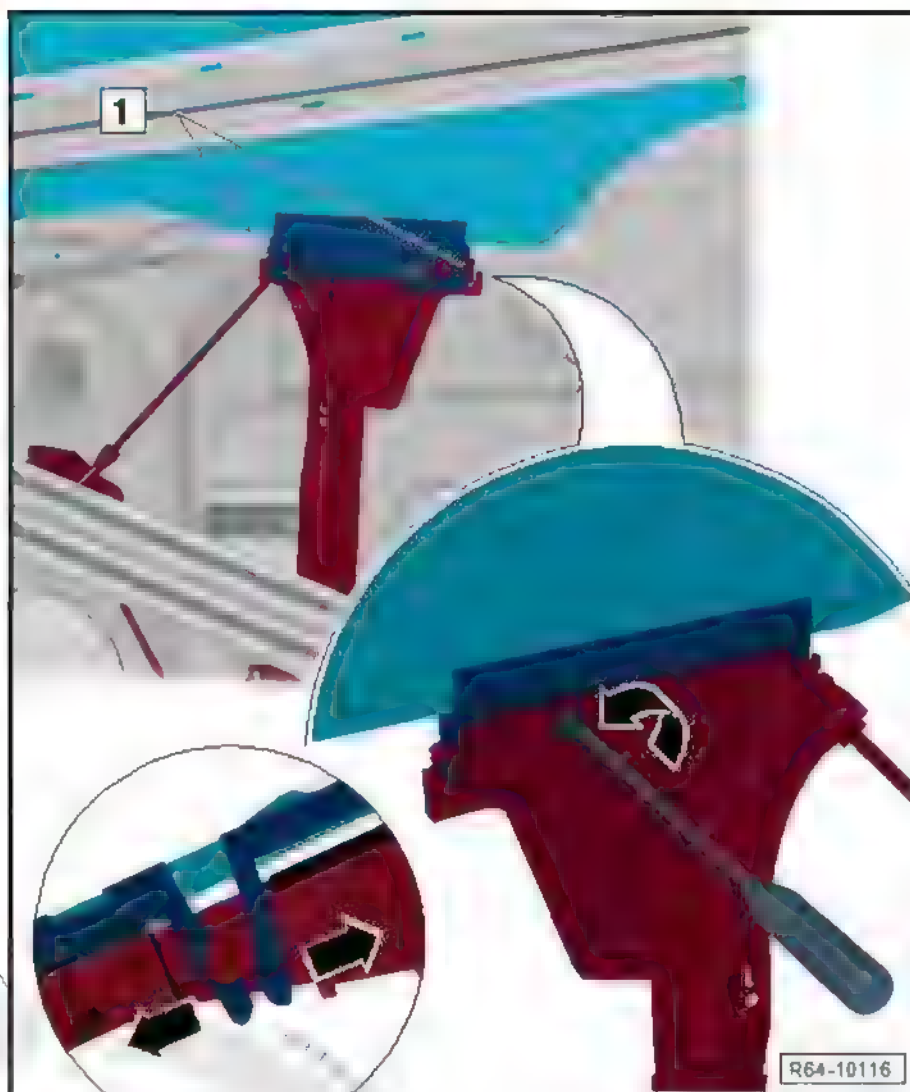
3.11.2 Install

- Installation is performed in the reverse sequence to the removal.

3.12 Rear door window power activation mechanism - remove and install

3.12.1 Remove

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove sealing membrane.
- Lower door window glass until the support is accessible on the window activation mechanism.



- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Push the door's window glass up and immobilize it.
- Drill "pop" rivets, lift the window activation mechanism from the couplings, and remove the set downward out through the door opening.

3.12.2 Install

Installation is performed in the reverse sequence to the removal, considering the following:

- Fasten the door window drive with "pop" rivets, and do not forget the washers.

3.13 Rear door window drive motor - remove and install

Remove

- Remove window power activation mechanism [page 175](#).

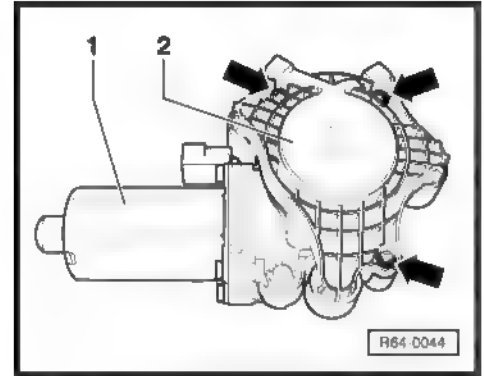


- Unscrew fastening screws -arrows-.
- Remove engine -1- from glass activation mechanism -2-.

Install

Install is performed in the reverse sequence, observing the following:

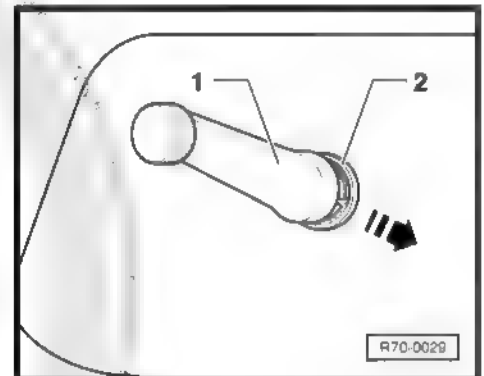
- Tighten the fastening screws to 3.5 Nm.
- Before installing the window power activation mechanism, check its operation.



3.14 Rear door window drive mechanism - remove and install

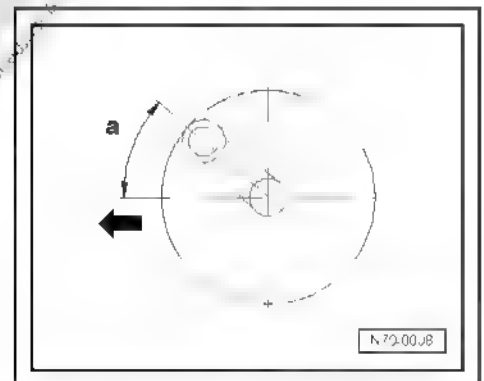
3.14.1 Remove

- With the door window fully closed, move the crank spacer in the indicated direction.
- Disengage the crank and remove it.



3.14.2 Install

- Installation is performed in the reverse sequence to the removal, considering the following:
- Position the crank at 45° in the indicated direction and fit the spacer.
- After assembling the door window glass, check the operation of the window activation mechanism. Figure "arrow" points wheeling direction.



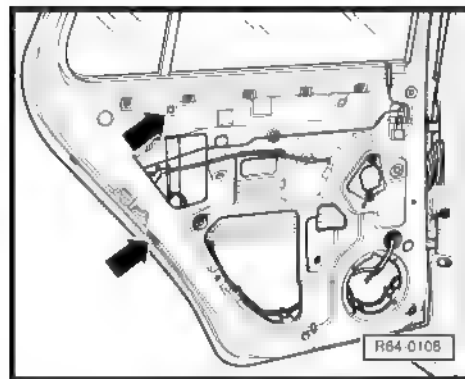
3.15 Rear door glass rear guide rail - remove and install

3.15.1 Remove

- Remove rear door window glass ➔ [page 174](#) .



- Remove screws from rear guide rail "arrows".
- Move rear door glass upper chute away along with the fixed glass.
- Remove rear guide rail, disengaging it from the door.



3.15.2 Install

- Installation is performed in the reverse sequence to the removal.

3.16 Rear door window channel - remove and install

- Remove the door window ⇒ [page 174](#) .
- Remove rear guide rail from rear door ⇒ [page 177](#)
- Carefully disengage and remove groove along with rear door fixed glass.

3.16.1 Install

- Installation is performed in the reverse sequence to the removal.

3.17 Rear door window internal trim - remove and install

3.17.1 Remove

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the trim by disengaging it from the door.

3.17.2 Install

- Installation is performed in the reverse sequence to the removal.

3.18 Rear door window external trim - replace

3.18.1 Remove

- Disengage trim and remove it.

3.18.2 Install

- Installation is performed in the reverse sequence to the removal.

3.19 Rear door fixed glass - replace

3.19.1 Remove



- Remove rear guide rail from rear door ➤ [page 177](#) .
- Disengage rear door window glass along with chute

3.19.2 Install

- Fit rear door window glass along with chute.
- Install rear door rear guide rail ➤ [page 177](#) .





66 – Exterior equipment

1 Materials used and operational care required

1.1 Auxiliary materials for Brazilian market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- | | |
|-----------------------------|---|
| ◆ PU 1K Adhesive | Betaseal U 400 HV - ⇒
Chemicals Manual;
Rep. gr. 00; Chemicals
- List of authorized
products ^{1, 2, 4} |
| ◆ Body Primer | Betaprime 5404 - ⇒
Chemicals Manual;
Rep. gr. 00; Chemicals
Manual - List of author-
ized products ¹ |
| ◆ Adhesive remover | D 002 000 10 ¹ |
| ◆ Activator for PP surfaces | D 181 655 R1 ^{1, 3} |
| ◆ Cutting wire | 357 853 999.A (1.25 x
6000 mm) |
| ◆ Silicone remover | LSE 020 100 A3 ¹ |
| ◆ Cleaning solution | D 009 401 04 ¹ |

15) Observe the procedural indications in accordance with the manufacturer's prescriptions for packaging disposal

16) Heat up according to manufacturer instructions Cartridge heater - VAG 1939-

17) Used only in polypropylene components with no applied base layer. Reapply in the application area in the event the layer has been damaged

18) Follow the minimum drying time ⇒ [page 182](#).

1.2 Auxiliary materials for export market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- | | |
|-----------------------------|---|
| ◆ 1K Glass adhesive | DH 009 100 - 300 ml or DH
009 100 03 - 110 ml ^{1, 3, 4} |
| ◆ Activator for PP surfaces | D 181 655 R1 ^{1, 2, 4} |



- ◆ Glass/painting primer D 009 200 02 ¹
- ◆ Cutting wire 357 853 999.A (1.25 x 6000 mm)
- ◆ Silicone remover LSE 020 100 A3 ¹
- ◆ Adhesive remover D 002 000 10 ¹
- ◆ Cleaning solution D 009 401 04 ¹
- ◆ Primer applicator D 009 500 25

19) Observe the procedural indications in accordance with the manufacturer's prescriptions for packaging disposal

20) Used only in polypropylene components with no applied base layer. Reapply in the application area in the event the layer has been damaged.

21) Heat up according to manufacturer instructions Cartridge heater - VAG 1939

22) Follow the minimum drying time ➔ [page 182](#).

1.3 Matching table

WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*



To help understanding, please find below a comparison table for materials used in the Brazilian and export markets

Product	Brazilian Market	Export Market
PU 1K Adhesive	Betaseal U-400 HV	DH 009 100 - 300 ml or DH 009 100 03 - 110 ml
Body primer	Betaprimer 5404	D 009 200 02

1.4 Paint damage - repair

WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*

Repaint ➔ Paint Manual - Paint repair in on steel plates and zinc-coated steel plates .

For paint damages in non visible areas the following repair method is recommended:

- Paint twice (humid on humid) with paint primer - D 009 200 02- . Use the primer applicator - D 009 500 25- - Minimum drying time for the primer is 10 minutes.



1.5 Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU)



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- Apply the adhesive remover - D 002 000 10- onto the affected surface. Follow the safety rules during the application.
- First, clean the painted surface with a dry cloth. Eliminate dirt remains with the adhesive remover - D 002 000 10- .

1.6 Minimum adhesive drying time

Minimum adhesive drying time is the period from the installation of the component until the delivery of the vehicle to the customer. This time is 3 hours. During this period, the vehicle must remain on a level surface and at room temperature (minimum 59° F).



WARNING

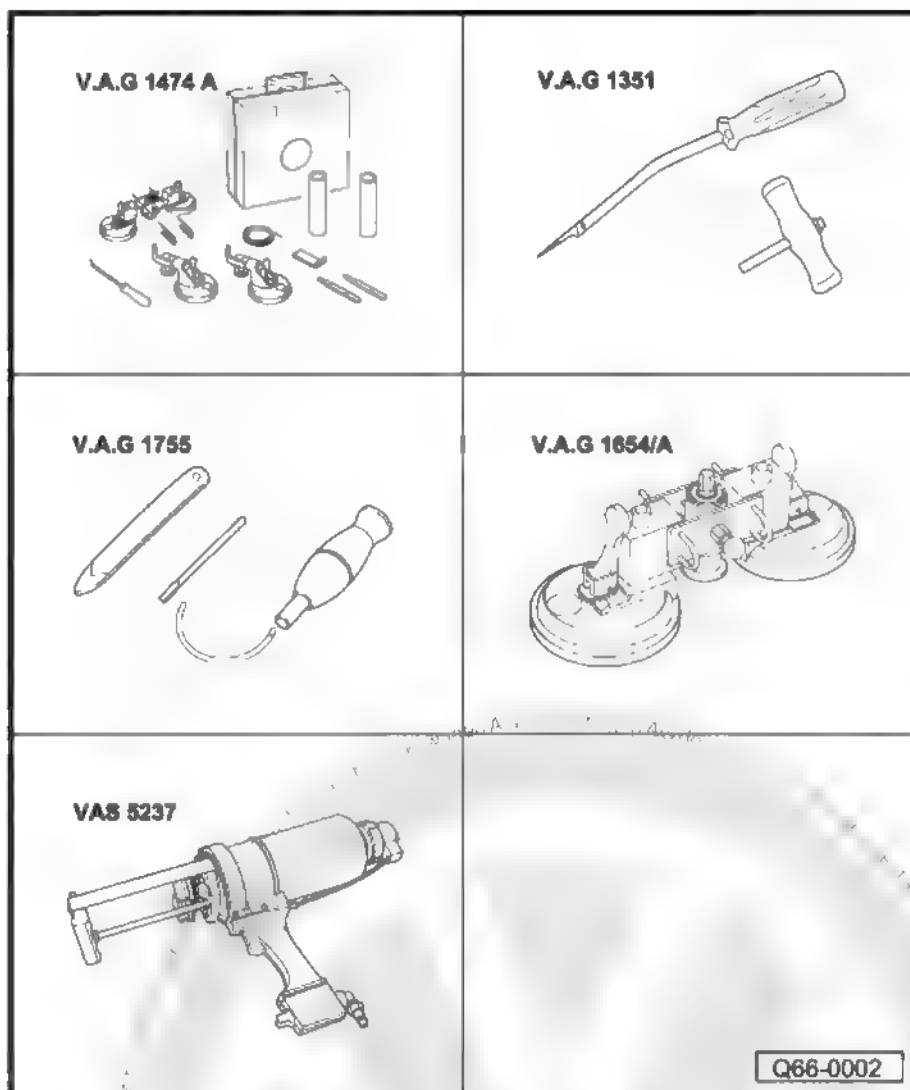
The vehicle can only be released after the minimum curing period has elapsed.



2 Spoiler

2.1 Roof spoiler (Fox) - assembly overview

Special tools and workshop equipment required



- ◆ Anchoring tool - VAG 1351-
- ◆ Glass removal tools - VAG 1474B- or Device with ratchet - VAG 1654A-
- ◆ Glass removal kit - VAG 1755-
- ◆ Pneumatic adhesive applicator - VAS 5237-



2.1.1 Materials



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- ◆ 2K- adhesive DA 004 600 A2^{1, 2}
- ◆ Mixing tube D 002 001
- ◆ Primer D 181 711 A1
- ◆ Cleaning solution D 009 401 04
- ◆ Primer Applicator D 009 500 25
- ◆ Adhesive remover D 002 000 10
- ◆ Cutting wire 357 853 999 A (1.25 x 6000 mm)

23) Respect the minimum drying time. ⇒ [page 189](#)

24) The adhesive pneumatic applicator - VAS 5237- must be used with these materials

2.1.2 Spoiler - assembly overview



1 - Spoiler

- ☐ Remove ➔ [page 185](#)
- ☐ Install ➔ [page 186](#)
- ☐ Installation instructions ➔ [page 188](#)
- ☐ Material: ABS + PC

2 - Primer application area on the body

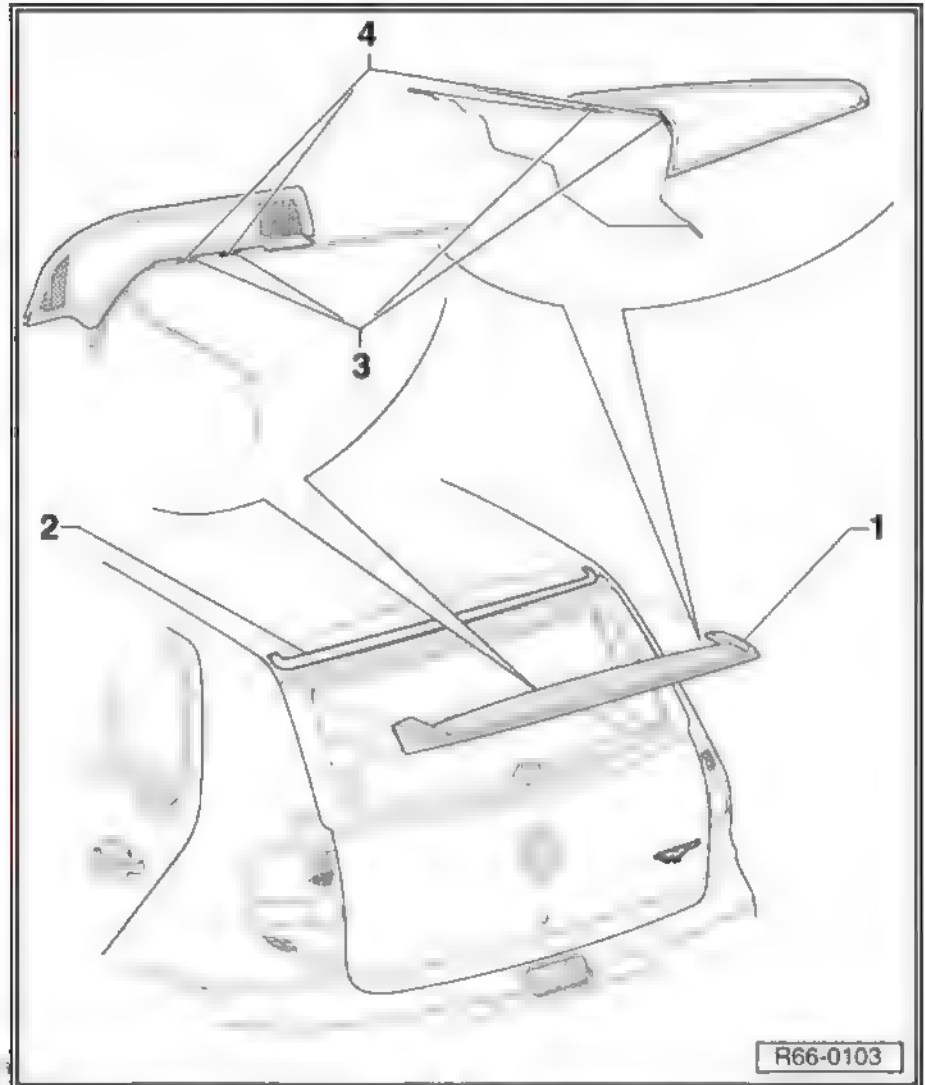
- ☐ Preparation ➔ [page 187](#)

3 - Adhesive

- ☐ Polyol + PUR pre-polymer

4 - Primer /adhesive application area on spoiler

- ☐ Preparation ➔ [page 187](#)



2.1.3 Spoiler - remove



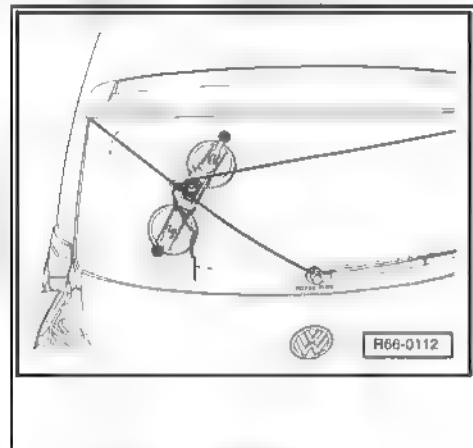
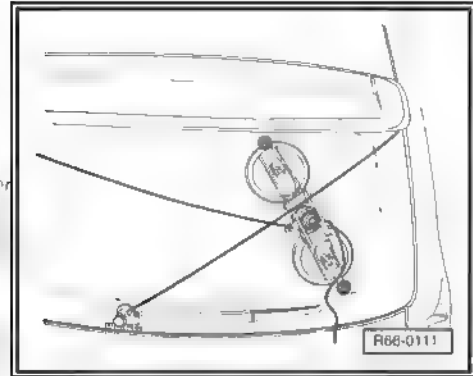
WARNING

Do not use any metallic cutting wire for removing the spoiler; otherwise, the paintwork may be damaged.

- Clean the spoiler support area so there is no damage to the paintwork when removing.
- Protect the rear door and the roof painting around the spoiler.



- Position the device with ratchet - VAG 1654A- as shown in the illustration and fasten one of the cutting wire ends. The other edge must be fixed on rear glass cleaner wiper blade shaft
- When cutting, introduce the cutting wire between the spoiler and the rear lid with a plastic wedge.
- Keep traction on cutting wire until approximately half the vehicle
- Reposition device with ratchet - VAG 1654A- as shown in the picture, and begin cutting once again from other side.
- Remove the spoiler.



2.1.4 Spoiler - install



1 - Spoiler

- ☐ Material: ABS + PC
- ☐ Installation instructions
➔ [page 188](#)

2 - Primer application area on the body

- ☐ Preparing the body for application of adhesive
➔ [page 187](#)
- ☐ Repairing damage to paintwork ➔ [page 189](#)



Note

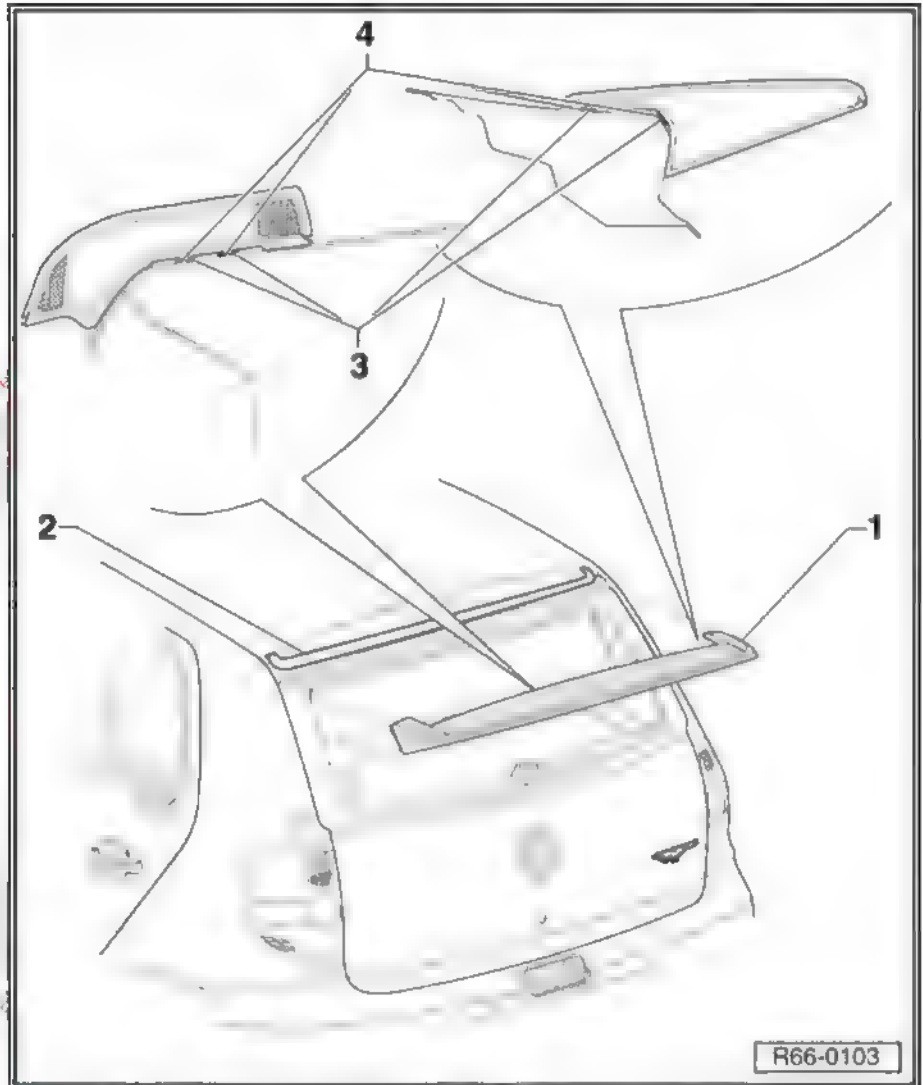
Minimum drying time -

3 - Adhesive

- ☐ Polyol + PUR pre-polymer
- ☐ Minimum adhesive curing time ➔ [page 189](#)

4 - Primer /adhesive application area on spoiler

- ☐ The adhesive bead must be:
 - ◆ 3-mm large
 - ◆ 5-mm high
- ☐ Cleaning the areas affected by the adhesive
➔ [page 189](#)



2.1.5 Preparing the body for application of adhesive



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ➔ *Electronic Parts Catalogue "ETKA"*



- Thoroughly clean the spoiler installation region.



Note

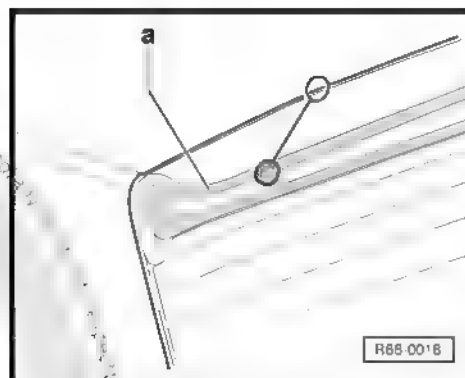
Old adhesive layer works as anchoring for the new cord. Adhesive application areas should be thoroughly free from dirt or oiliness.

If spoiler is not installed immediately after cutting old adhesive layer -a-, then it shall be activated with activator - D 181 801 A1-.



WARNING

The activator must not contact the painted surface. Otherwise, the painting will be damaged.



- ◆ If rear lid is replaced or repainted, apply primer for body - D 009 200 02- using the applicator - D 009 500 25-

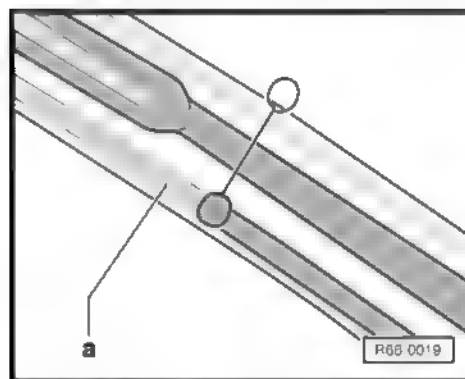
2.1.6 Installation instructions



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

- Prepare body for application of adhesive = [page 187](#)
- Remove the adhesive remains with the adhesive remover - D 002 000 10-.
- Moisten a cloth with the silicone remover - LSE 020 100 A3-.
- Clean thoroughly the adhesive application area with cloth soaked with solvent.
- Apply Primer homogeneously with the applicator - D 009 500 25-.
- ◆ The drying time is of approximately 10 minutes.



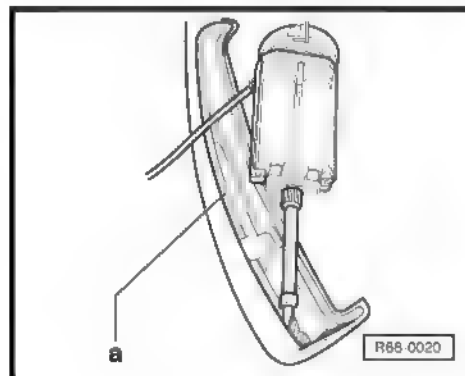
- Apply adhesive under primer application -a- area on spoiler.



WARNING

The spoiler must be installed within 10 minutes after applying the primer. Otherwise, the adherence will be impaired.

During the drying period, fasten the spoiler with masking tape.





2.1.7 Minimum adhesive drying time



WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"

Minimum adhesive curing time is the period from the spoiler installation to the delivery of the vehicle to the customer. This time is 3 hours. During this period, the vehicle must remain on a level surface and at room temperature (minimum 59° F).



Note

The vehicle can only be released after the minimum curing period has elapsed.

2.1.8 Repairing damage to paintwork



WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"

Repaint according to ⇒ Paint manual - Repairing paintwork in plastic parts .

If damages to paint occur in areas which are not visible from outside, apply body primer - D 009 200 02-



Note

Minimum drying time is 10 minutes.

2.1.9 Cleaning the areas affected by the adhesive



WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"

- The painted surfaces should be cleaned using a clean and dry cloth. Clean the other areas with the adhesive remover - D 002 000 10- .



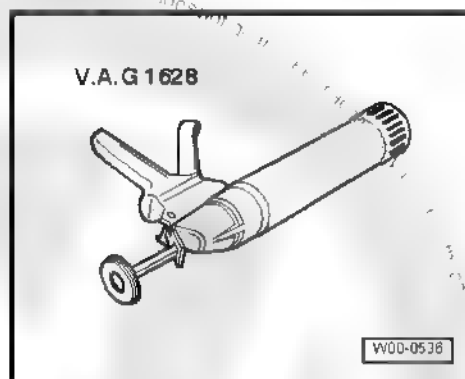
Note

The adhesive remover - D 002 000 10- is the cleaning agent. All safety rules must be followed.

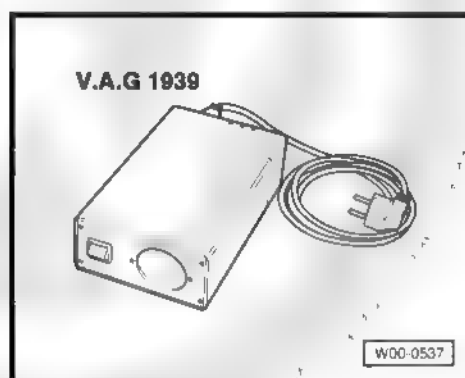
2.2 Spoiler (Spacefox) - remove and install

Special tools and workshop equipment required

- ◆ Manual pressure gun - VAG 1628- or Pneumatic Adhesive applicator for glued glasses - EQ 7434-



- ◆ Cartridge heater - VAG 1939- or Cartridge heater - VAG 1939A-



- ◆ Traction cable - VAG 1351/1-



2.3 Assembly overview



1 - Adhesive bead

- ☐ The adhesive cord must be 9^{+1} mm wide and 6^{+1} mm high.

2 - Spoiler

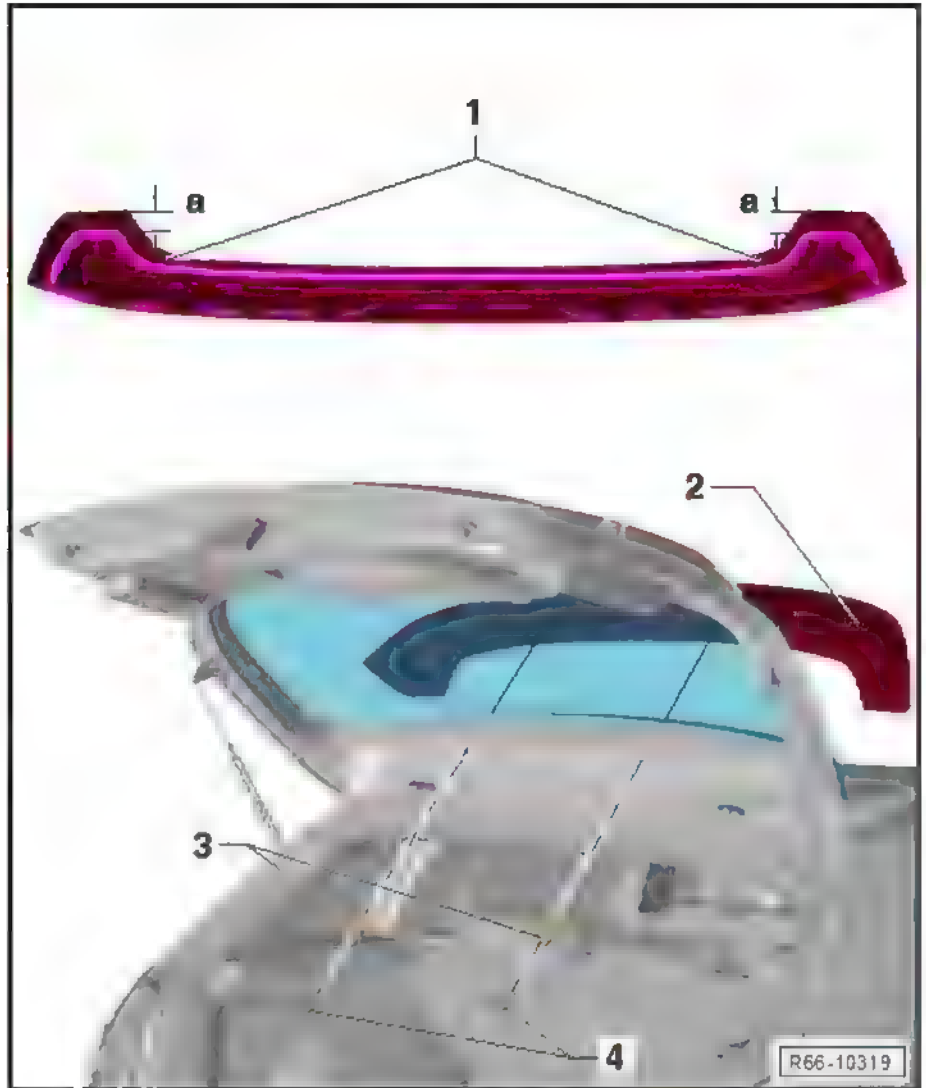
- ☐ Remove → [page 191](#)
- ☐ Install → [page 193](#)

3 - Bolt

- ☐ 2 units
- ☐ Torque: 3 Nm

4 - Plug

- ☐ 2 units



2.4 Observations for the execution of the removal and installation of the spoiler

Auxiliary materials Brazilian market → [page 180](#)

Auxiliary materials for the export market → [page 180](#)

Matching table → [page 181](#)

Minimum adhesive curing time → [page 181](#)

Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU) → [page 182](#)

Paintwork damage - repair → [page 181](#)

2.5 Remove



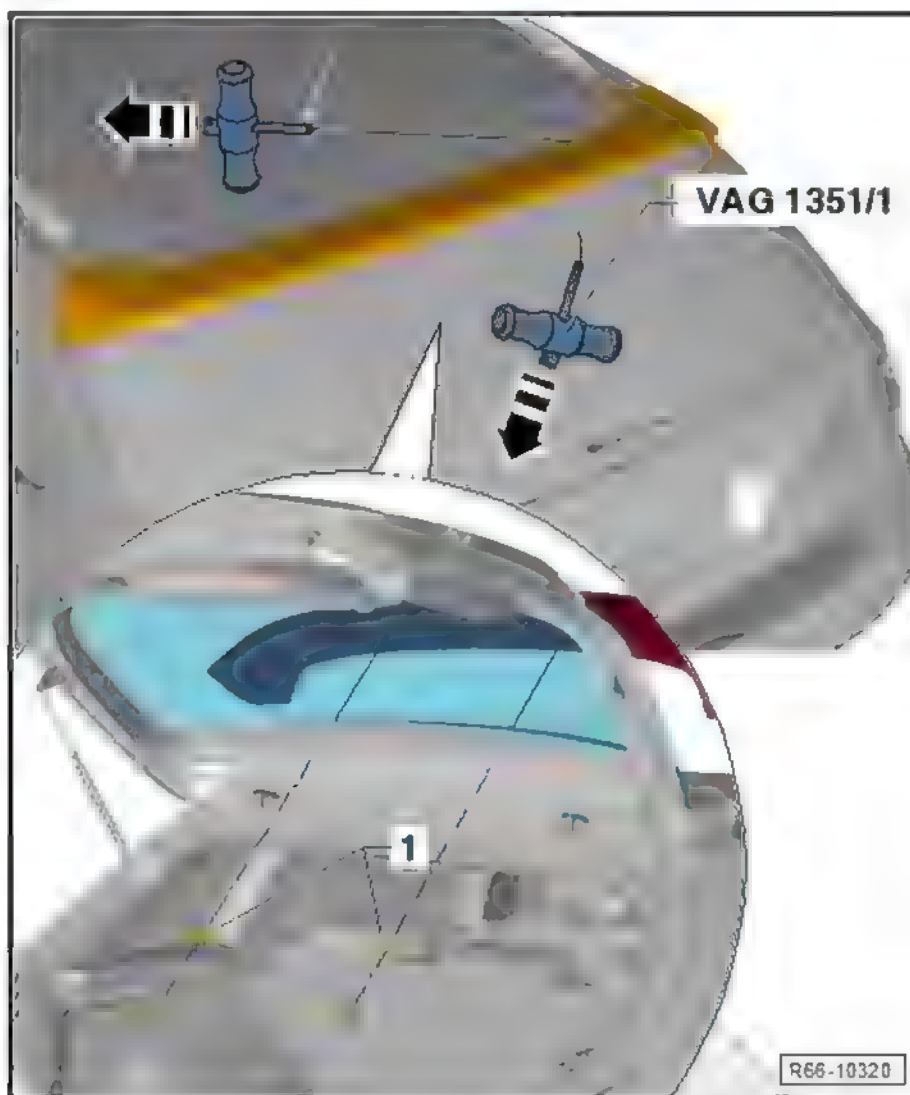
WARNING

Do not use any metallic cutting wire for removing the spoiler; otherwise, the paintwork may be damaged.

- Clean the spoiler support area so there is no damage to the paintwork when removing.



- Protect the paintwork of the rear lid and the roof around the spoiler with adhesive tape.



- Remove plugs and bolts -1- fastening the spoiler.
- Fasten the cutting wire - 357 853 999.A- to two traction cables - VAG 1351/1- .
- Position the cutting wire between the spoiler and the door and, after that, traction the cutting wire through the traction cables - VAG 1351/1- .
- Remove the spoiler.



2.6 Install

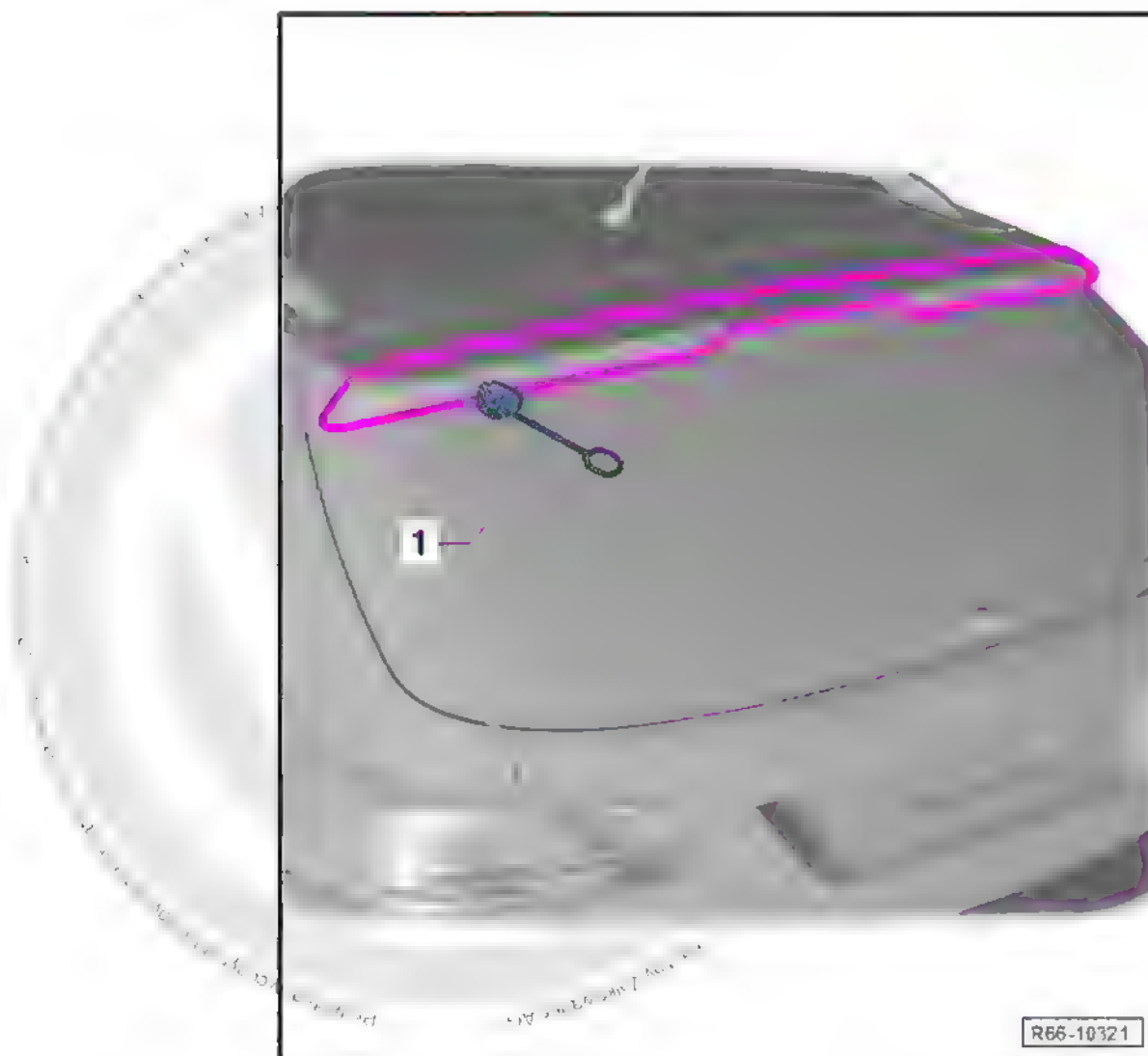
2.6.1 Preparing the body for application of adhesive



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- Cut the adhesive layer on the rear lid and on the spoiler, reducing it to -1 mm-high, approximately.
- Remove the paintwork protection masking tape.
- Carefully clean the spoiler contact area -1- with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04-
- Repair any damage to the paintwork ⇒ [page 181](#) .





Note

- ◆ *The residual adhesive bead serves as the adherence base for the new bead. The gluing areas should be thoroughly free from dirt or oiliness.*
- ◆ *For replacement lids/ apply primer - D 009 200 02- with applicator - D 009 500 25- -1- in the application area of the PU adhesive. The drying time of the primer is 10 minutes.*
- ◆ *See "Observations for operational execution" ➔ [page 191](#) .*

2.6.2 Installation instructions



WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*

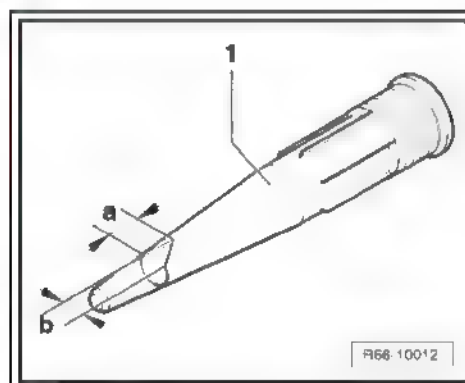
The surfaces where the Primer is to be applied should be free from residues/dirt.

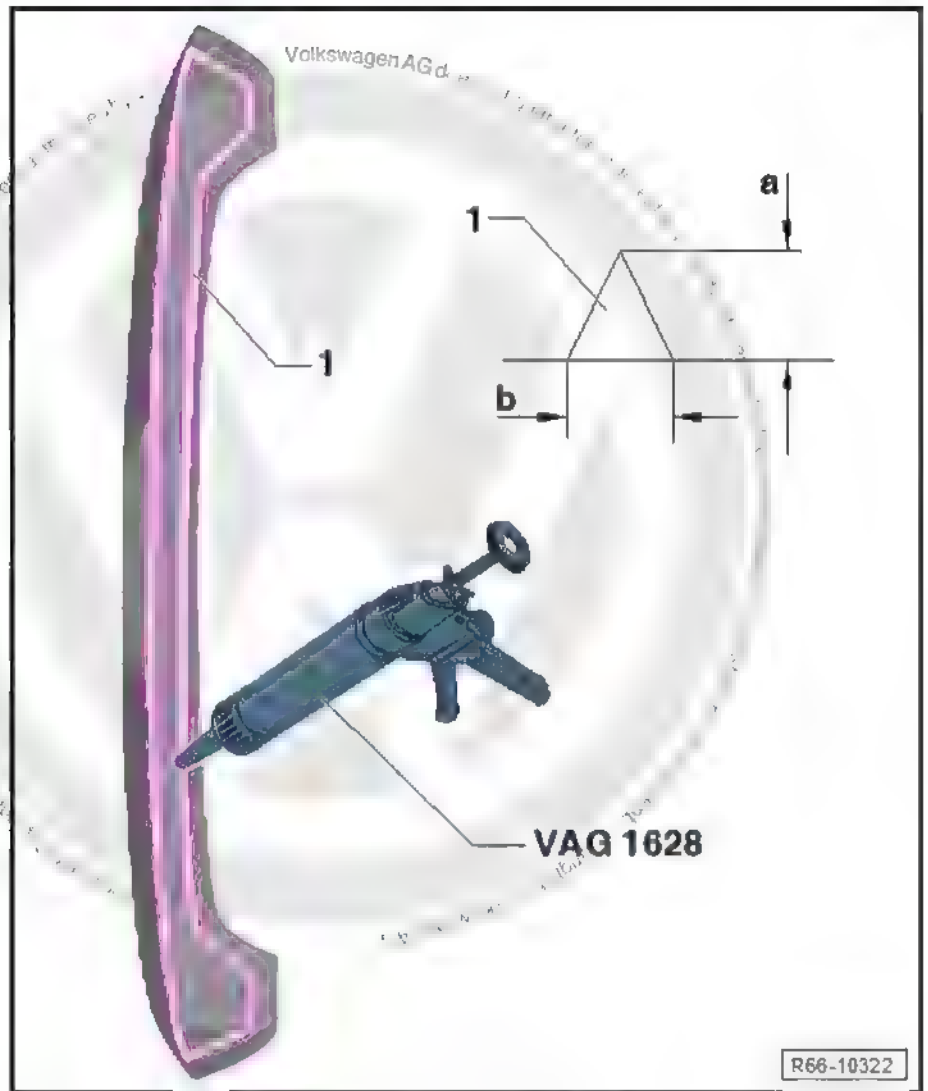
- ✚ Remove the adhesive remains with the adhesive remover - D 002 000 10- .
- ✚ Moisten a cloth with the silicone remover - LSE 020 100 A3- . Clean thoroughly the adhesive application area with cloth.



Note

- ◆ *For replacement spoilers, apply primer - D 009 200 02- with an applicator - D 009 500 25- in the application area of the PU adhesive. The drying time of the primer is 10 minutes.*
- ◆ *See "Observations for operational execution" ➔ [page 191](#) .*
- Cut adhesive dispenser -1- nozzle.
- $a = 9^{+1}\text{mm}$
- $b = 6^{+1}\text{mm}$
- Heat the DH 009 100 - 300 ml or DH 009 100 03 - 110 ml adhesive cartridge up, with a cartridge heater - VAG 1939- or cartridge heater - VAG 1939A- .





- Apply the adhesive with the application of primer with a manual pressure pistol - VAG 1628- or pneumatic adhesive applicator for glued windows - EQ 7434- .



WARNING

Pay attention to the dimensions of the adhesive cord, - 9 mm high - and - 6 mm wide -.

The roof spoiler must be installed, at the most, 10 minutes after applying the adhesive. Otherwise, the adherence will be impaired.

- ◆ The openings must be at least 1 mm.
- ◆ During the curing period, fasten the spoiler with masking tape.
- Position the roof spoiler with the help of an assistant.



Note

- ◆ *Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU) → [page 182](#)*
- ◆ *Await the minimum drying time → [page 182](#)*





3 Roof Rack

3.1 Roof rack (Crossfox) - remove and install

1 - External door trim

2 - Rack

☐ Remove

- Loosen screw -5- and remove screw -3-.

- Remove the rack.

☐ Install

- Installation is performed in the reverse sequence to the removal.



Note

Screw tightening -5- must be performed gradually and simultaneously on both sides. Initially tighten screw on left with "1 Nm" and right sequence with finally left and right with

3 - Bolt

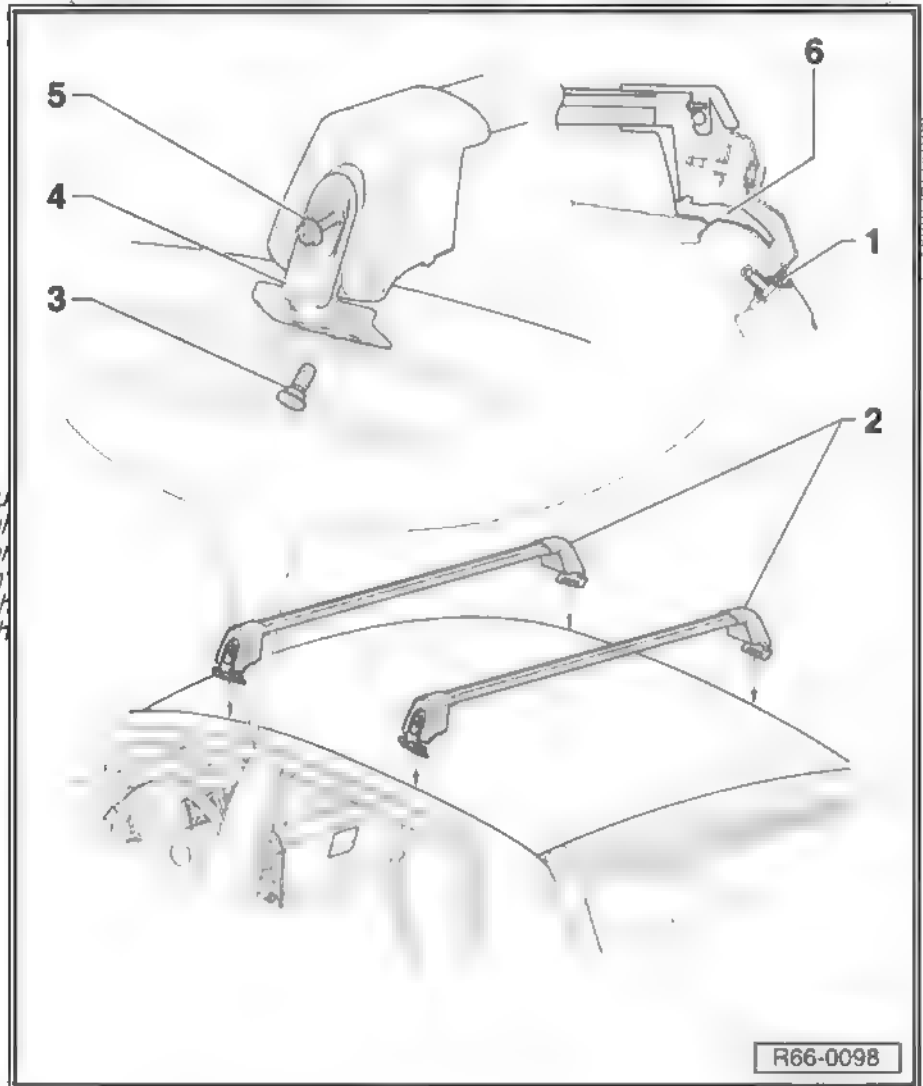
☐ Torque: 4 Nm

4 - Mounting bracket

5 - Bolt

☐ Torque: 6 Nm

6 - Rubber wedge

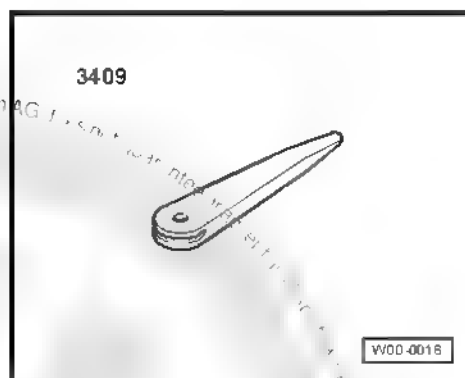


3.2 Roof rack (Spacefox) - remove and install

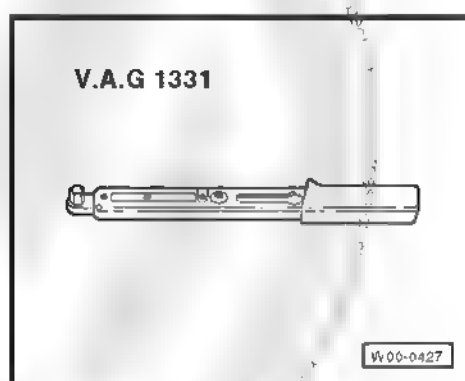
Special tools and workshop equipment required



- ◆ Wedge - 3409- or scraper (5 parts) - VW 037-

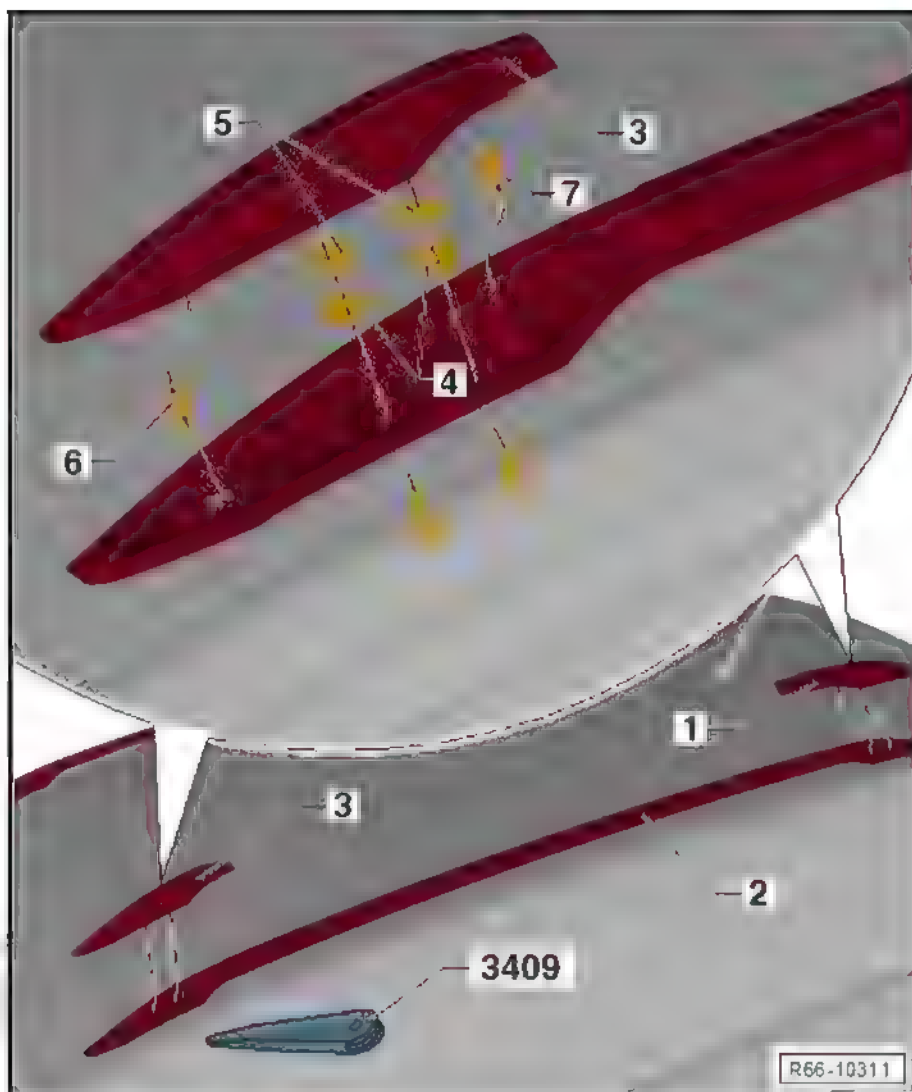


- Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



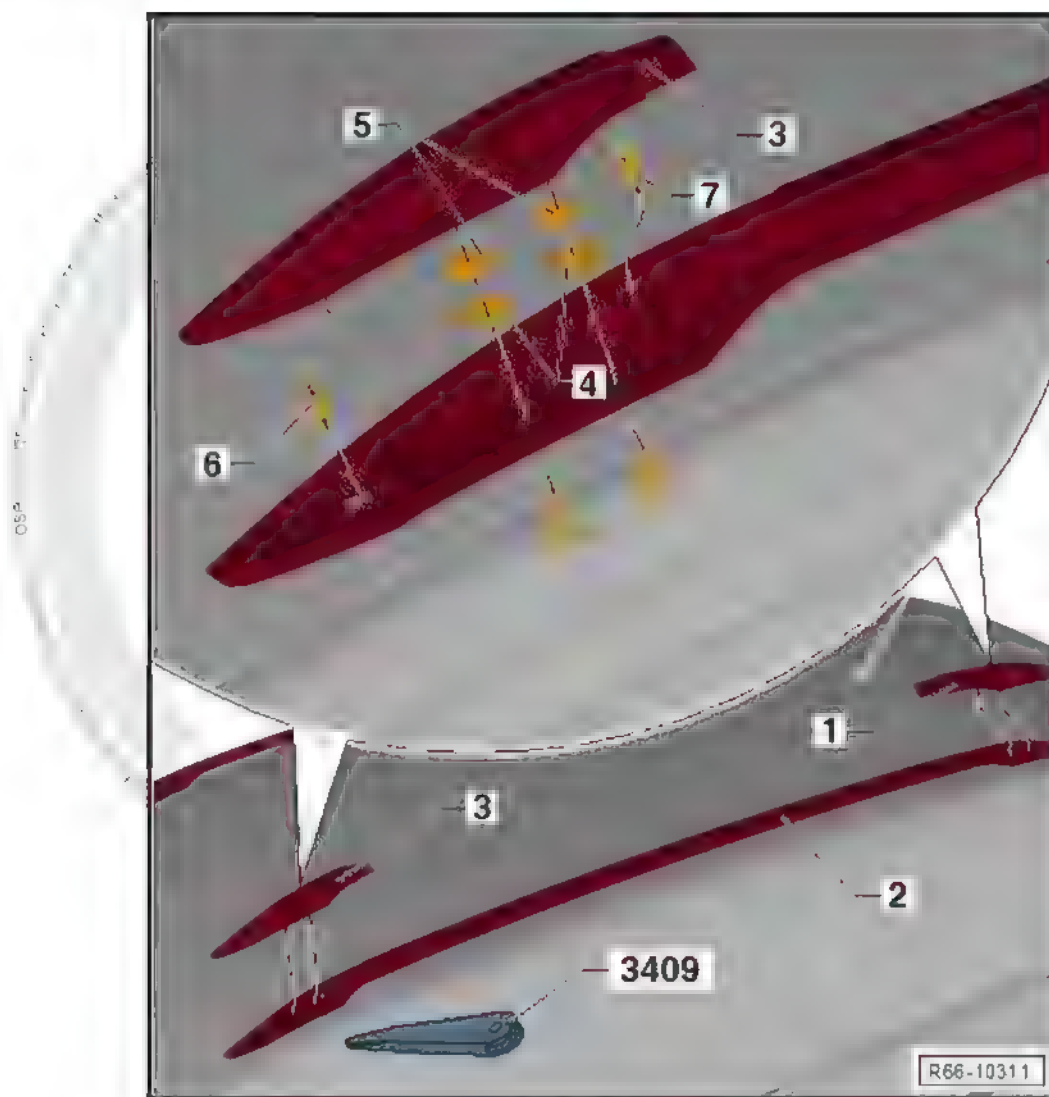


- 1 - Rear fastening cover
 - ☐ disengage using the wedge - 3409- .
- 2 - Roof rack
- 3 - Front fastening cover
 - ☐ disengage using the wedge - 3409- .
- 4 - Spherical washer
 - ☐ 2 units
- 5 - Nut
 - ☐ 4 units
 - ☐ Torque: 20 Nm
- 6 - Retaining catch
 - ☐ replace if necessary
- 7 - Fitting pin
 - ☐ replace if necessary



Remove

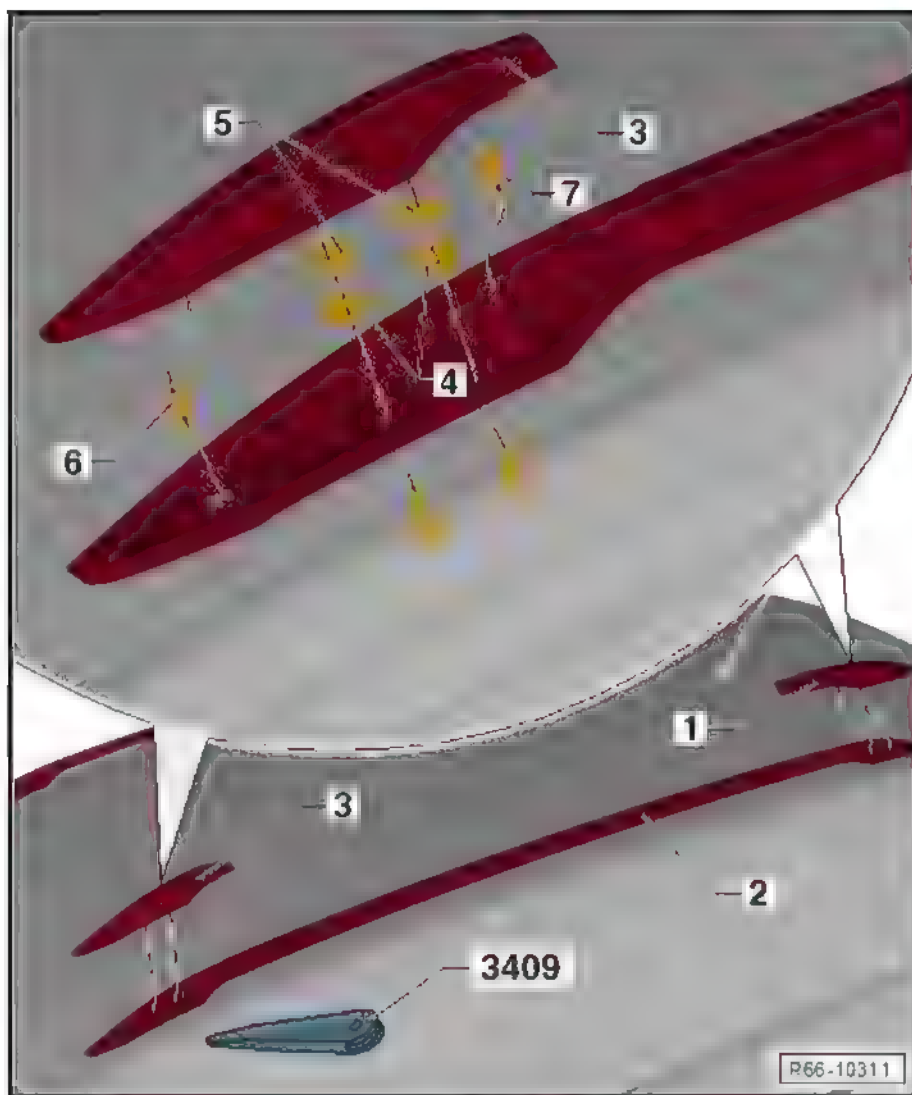
To/s



- Remove front -3-and rear -1- fastening covers.
- Remove nuts -5- and washers -4-.
- Carefully remove the rack -2-.

Install

- Place the rack under the roof.



- Install spherical washers -4- and install nuts -5-.
- Tighten evenly the securing bolts, first from front and then from rear fastening.
- Install front -3-and rear -1- fastening covers.



3.3 Roof rack fastening support (Spacefox) - replace

1 - Nut

- ☐ 2 units
- ☐ Torque: 20 Nm

2 - Spherical washer

- ☐ 2 units

3 - Supporting plate with seal

- ☐ PE Foam



Note

The PE foam seal is essential to prevent leaking to inside the vehicle.

4 - Washer

5 - Bolt

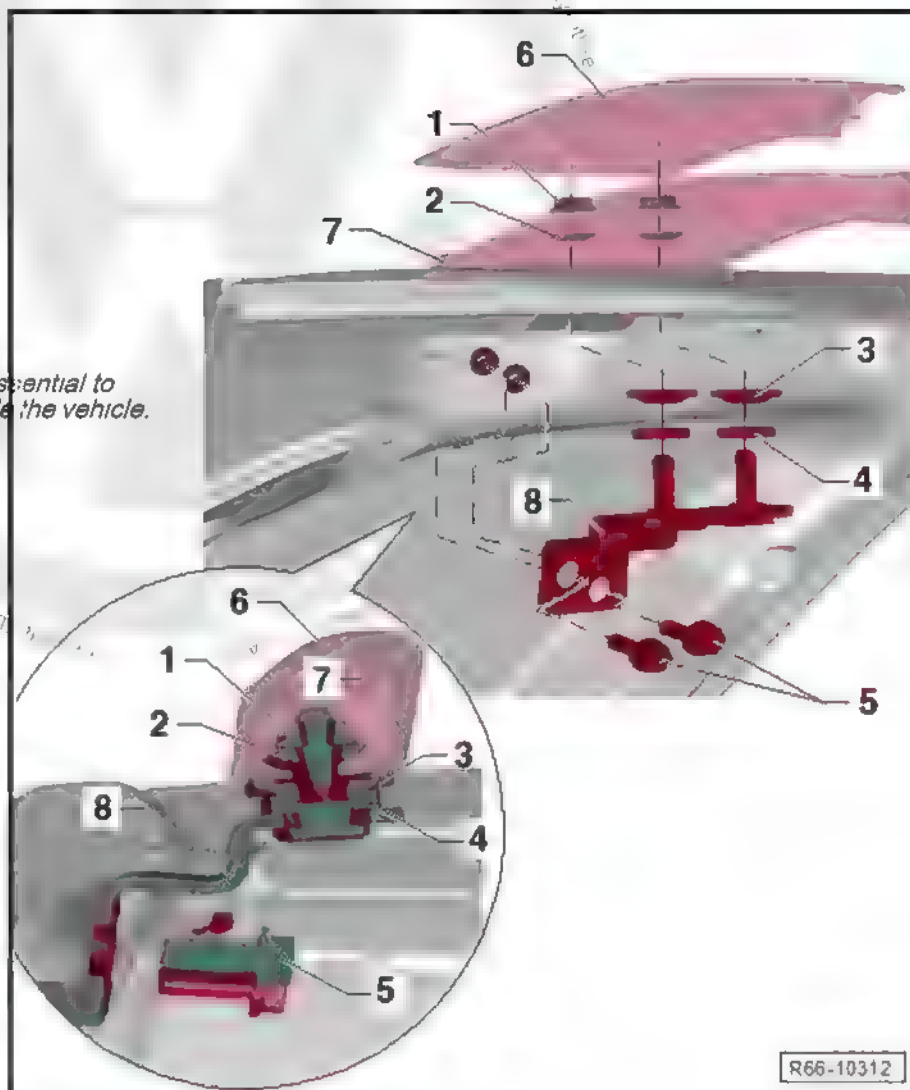
- ☐ 2 units
- ☐ Torque: 20 Nm

6 - Fastening cover

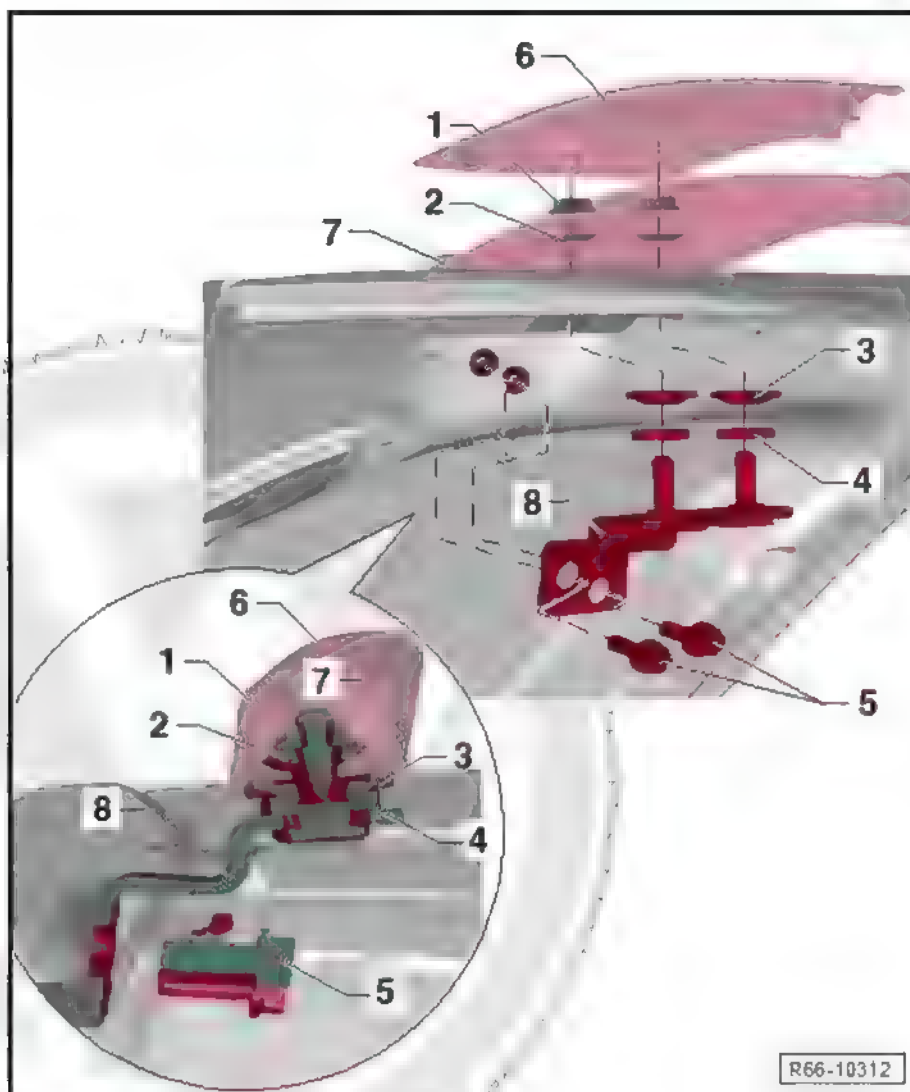
7 - Roof rack

- ☐ Remove and install
⇒ [page 197](#)

8 - Roof rack fastening support

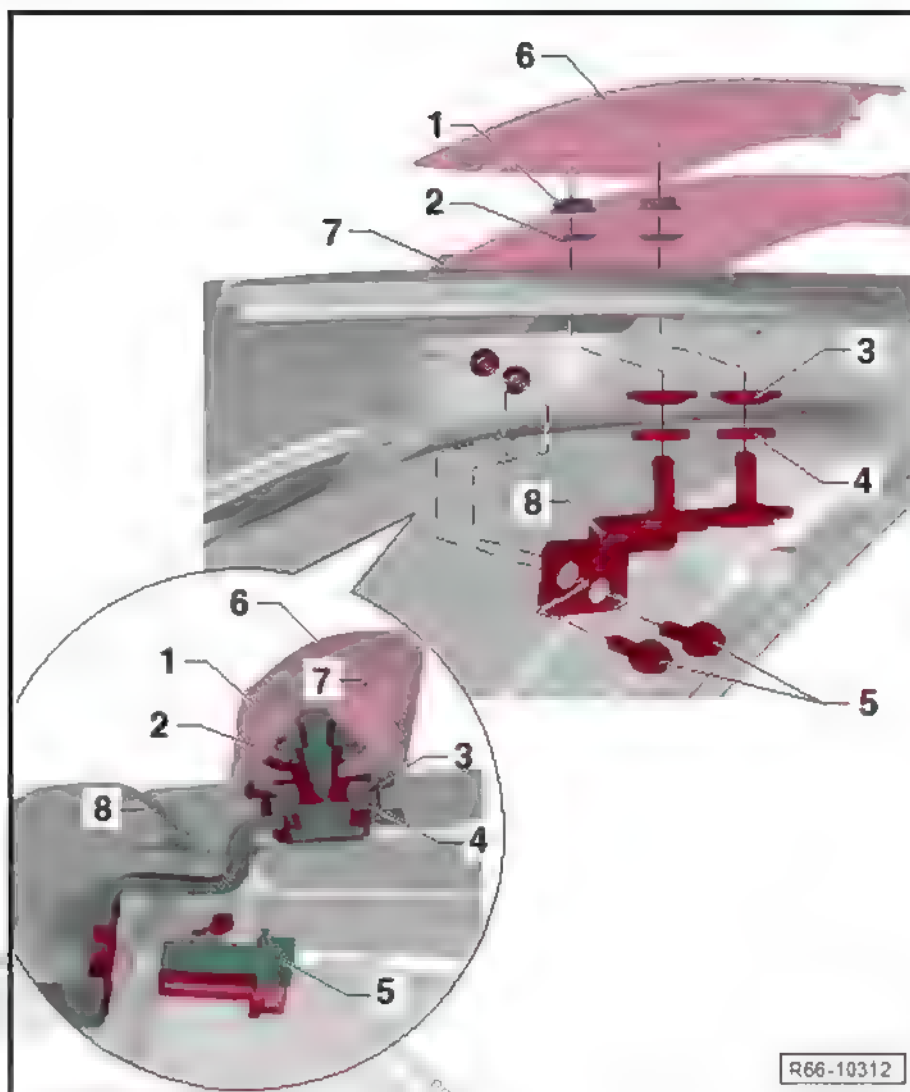


Remove



- Remove the roof rack ➤ [page 197](#).
- Remove roof lining ➤ General body repairs, interior, Rep. gr. 70 ; Lining / insulation .
- Remove securing bolts -5- from support.

Install



- Place the support -8-, and install securing bolts -5- to support.



Note

Check in advance the conditions of the PE foam in the supporting plate with seal -3- to avoid potential leaking.

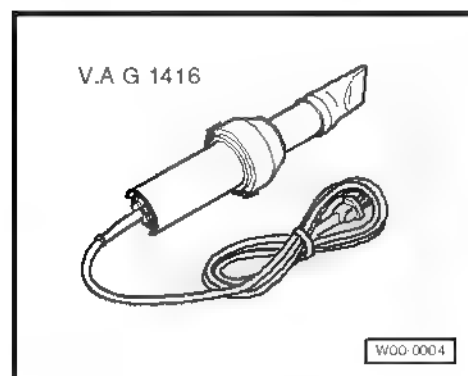
- Remove roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Install the roof rack ➤ [page 197](#) .



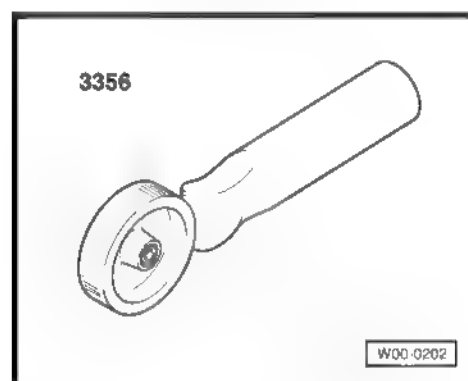
4 Inscriptions

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



4.1 (1.6) version lettering - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Remove



Note

Heat the badge using the hot air blower VAG 1416- prior to removal

- Detach the badge with a plastic scraper
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



Install

- Remove the double-sided tape liner and glue the badge as indicated. Use pressure roll - 3356-

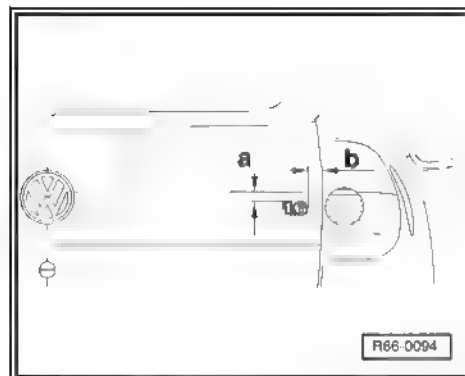
a = 15 mm

b = 35 mm



Note

Elevations are the same for other badges: "1.4", "SDI" and "TDI"



4.2 Model lettering (Fox) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Remove



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416-.

- Detach the badge with a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 10-, and apply the cleaning solution - D 009 401 04-. Scrub the surface with a cloth until it is completely dry.

Install

- Remove the double-sided tape liner and glue the badge as indicated. Use pressure roll - 3356-

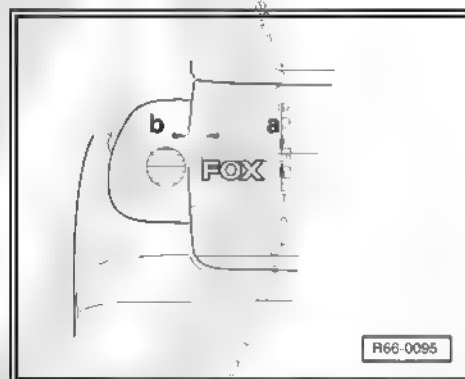
a = 15 mm

b = 35 mm



Note

Elevations are the same for the "LUPO" badge.





4.3 "Total Flex" badge - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*

Remove



Note

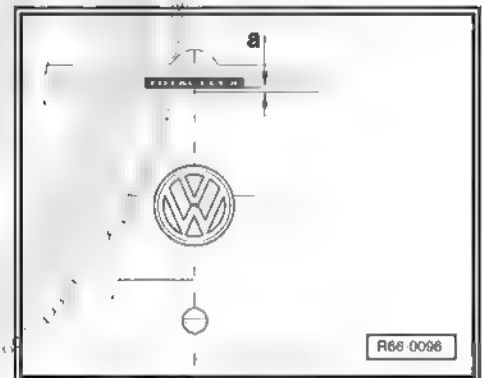
Before removal, you must heat up the badge with the hot air blower - VAG 1416-.

- Detach the badge with a plastic scraper.
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Install

- Remove the double-sided tape liner and glue the badge as indicated. Use pressure roll - 3356-

a = 6 mm



4.4 Plus version badge (side) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*

Remove



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416-.

- Detach the badge with a plastic scraper
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



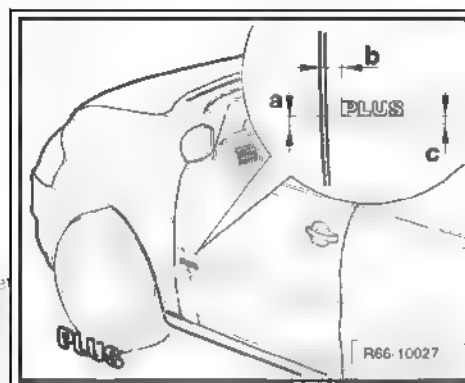
Install

- Remove the double-sided tape liner and glue the badge as indicated. Use pressure roll - 3356-

a = 20 mm

b = 50 mm

c = 19 mm



4.5 Version and "Total Flex" Badge (Cross-Fox) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"

Remove



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416-.

- Detach the badge with a plastic scraper.
- Clean rear lid using the adhesive remover - D 002 000 10-, and apply the cleaning solution - D 009 401 04-. Rub the surface with a cloth until it is completely dry.

Install

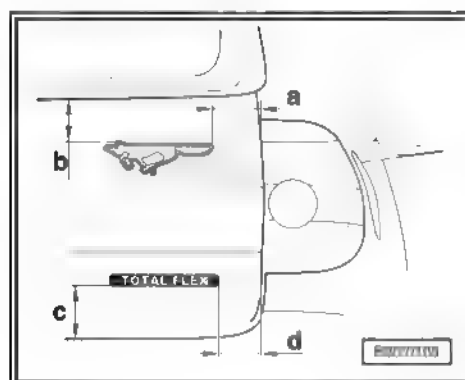
- Remove the double-sided tape liner and glue the badge as indicated. Use pressure roll - 3356-

a = 40 mm

b = 78 mm

c = 65 mm

d = 35 mm





4.6 Wing and front door decorative stripe (Fox Extreme) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*

Remove



Note

Before removal, heat up the decorative stripe with the hot air blower - VAG 1416-.

- Detach decorative stripe with a plastic spatula.
- Clean wing/door with adhesive remover - D 002 000 10- and apply cleaning solution - D 009 401 04- . Scrub surface with a cloth until it is completely dry

Install

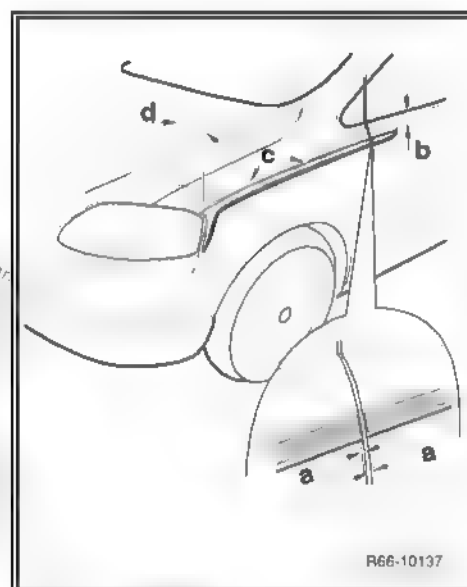
- Remove decorative stripe liner and glue it as indicated. Use pressure roll - 3356-

a = 4 mm

b = 50 mm

c = tangent to shine line

d = 80 mm



4.7 Rear door decorative stripe (Fox Extreme) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*



Remove



Note

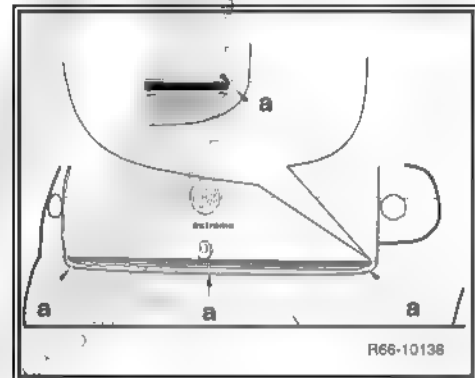
Before removal, heat up the decorative stripe with the hot air blower - VAG 1416-.

- Detach decorative stripe with a plastic spatula
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Install

- Remove decorative stripe liner and glue it as indicated. Use pressure roll - 3356-

a = 3 mm



4.8 "Fox extreme" (Fox Extreme) Inscription - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

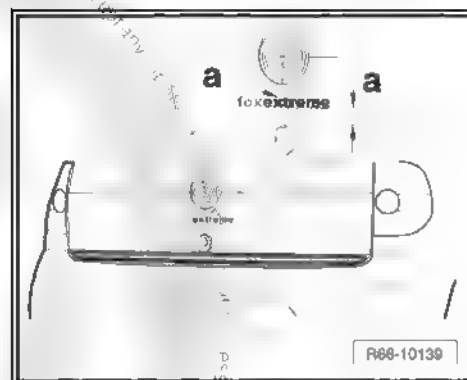


Install

- Remove adhesive liner from badge and attach as indicated
Use a pressure roll - 3356-

a = badge center

b = 35 mm



4.9 "Fox-shape" badge on door (Fox Extreme) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean door with adhesive remover - D 002 000 10- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Install

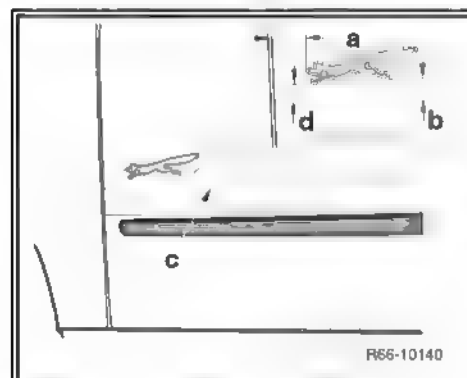
- Remove adhesive liner from badge and attach as indicated.
Use a pressure roll - 3356-

a = 50 mm

b = 24 mm

c = radius line

d = 20 mm





4.10 Side badge - BlackFox version (Fox BlackFox) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Remove



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416-.

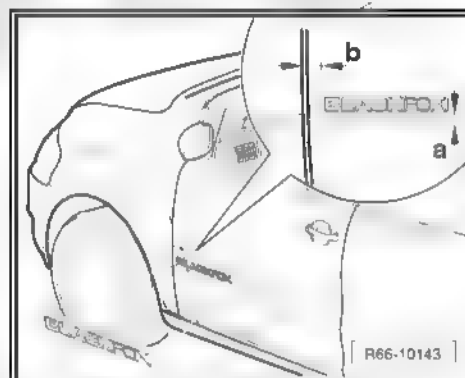
- Detach the badge with a plastic scraper.
- Clean rear lid using the adhesive remover - D 002 000 10-, and apply the cleaning solution - D 009 401 04-. Scrub the surface with a cloth until it is completely dry.

Install

- Remove the double-sided tape liner and glue the badge as indicated. Use pressure roll 3356-

a = 18 mm

b = 25 mm



4.11 "BlackFox" (Fox BlackFox) Badge on rear door - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.



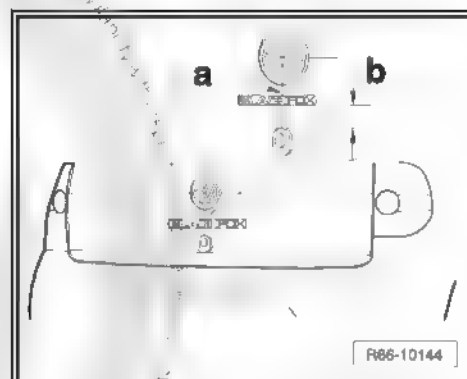
- Clean rear lid using the adhesive remover - D 002 000 10- and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Install

- Remove adhesive liner from badge and attach as indicated
Use a pressure roll - 3356-

a = badge center

b = 35 mm



4.12 Rear side panel "Refresh" (Fox Refresh) Badge - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

Remove



Note

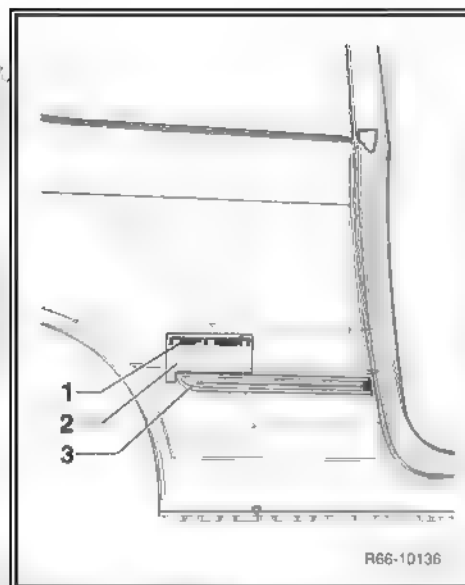
Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean rear side panel with adhesive remover - D 002 000 10- and apply cleaning solution - D 009 401 04- . Scrub the surface with a cloth until it is completely dry.



Install

- 1 - Refresh Badge
 - 2 - Guide liner
 - 3 - Rear side panel trim
- Place the badge using guide liner -2- supported by the rear side panel trim -3-. Remove badge liner and glue it as indicated. Use pressure roll - 3356-



4.13 "Fox Sunrise" (Fox Sunrise) badge on rear door - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Scrub the surface with a cloth until it is completely dry.

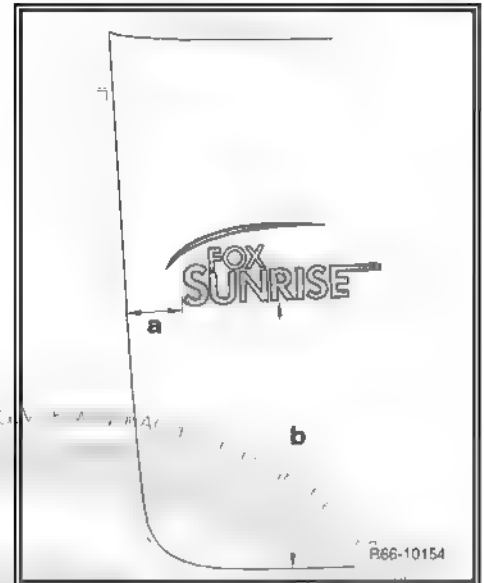


Install

- Remove adhesive liner from badge and attach as indicated
Use a pressure roll - 3356-

a = 42 mm

b = 197 mm



4.14 "Fox Sunrise" (Fox Sunrise) badge on rear side - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean rear hatch using the adhesive remover - D 002 000 10- and apply the cleaning solution - D 009 401 04- . Scrub the surface with a cloth until it is completely dry.



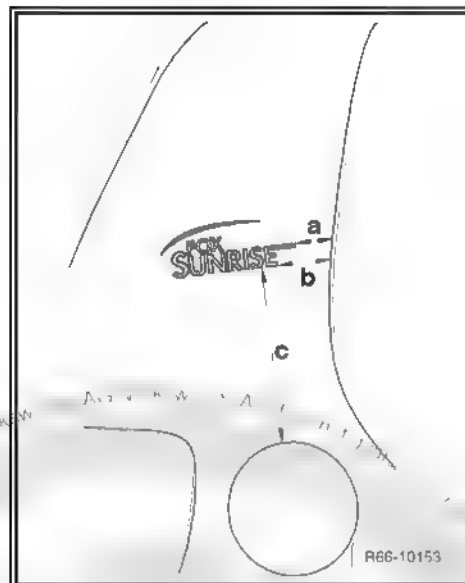
Install

- Remove adhesive liner from badge and attach as indicated
Use a pressure roll - 3356-

a = 42 mm

b = 60 mm

c = 206 mm



4.15 "Fox Sunrise" (Fox Sunrise) Badge on external rear-view mirror case - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean external rear-view mirror case with adhesive remover - D 002 000 10- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

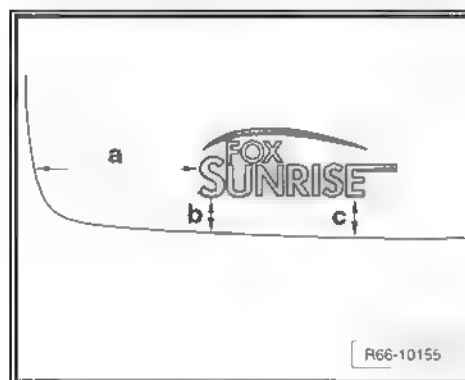
Install

- Remove adhesive liner from badge and attach as indicated.
Use a pressure roll - 3356-

a = 50 mm

b = 10 mm

c = 11 mm





4.16 "Spacefox" lettering on rear lid - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

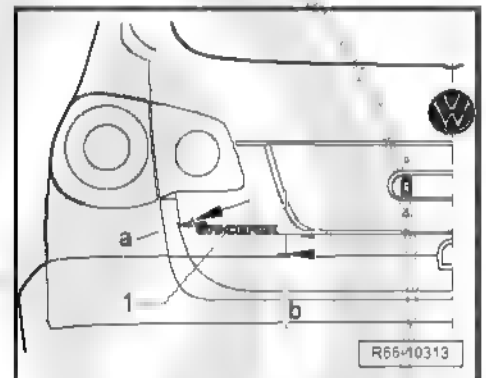
- Detach badge -1- using a plastic scraper.
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Install

- Remove adhesive liner from badge and attach as indicated. Use a pressure roll - 3356-

a = 30 mm

b = 45 mm



4.17 "1.6" lettering on rear lid (Spacefox) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Remove



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach badge -1- using a plastic scraper.



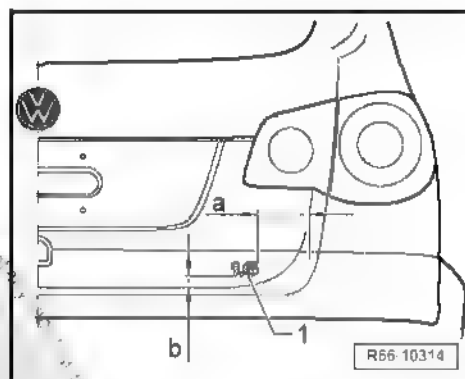
- Clean rear lid using the adhesive remover - D 002 000 10- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Install

- Remove adhesive liner from badge and attach as indicated. Use a pressure roll - 3356-

a = 80 mm

b = 45 mm



4.18 Decorative stripe on bumper rear protector - replace



WARNING

- When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"

Remove



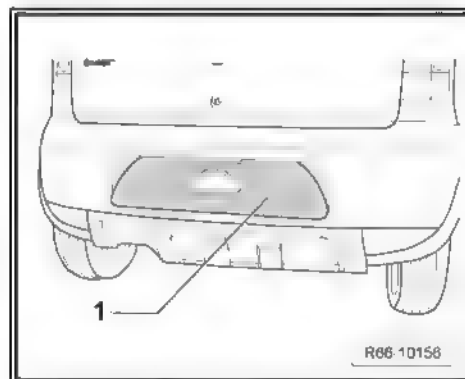
Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach rear protector decorative stripe -1- with a plastic spatula.
- Clean rear protector with adhesive remover - D 002 000 10- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Install

- Remove decorative stripe liner and glue it as indicated. Use pressure roll - 3356-





4.19 CrossFox (➤ 2007) side badge - replace



WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"

1 - "FOX" badge gluing area

- ☒ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

2 - "FOX" badge

- ☐ self-adhesive
- ☐ Rear bumper central protection
- ☐ Heat badge using the hot air blower - VAG 1416- prior to removal.
- ☐ Remove badge liner, place the badge plastic foil in relation to the door crease -5-, carefully press in order not to trap air bubbles into the badge, then press it strongly using the pressure roll - 3356- . Operating temperature approx. 20°C.

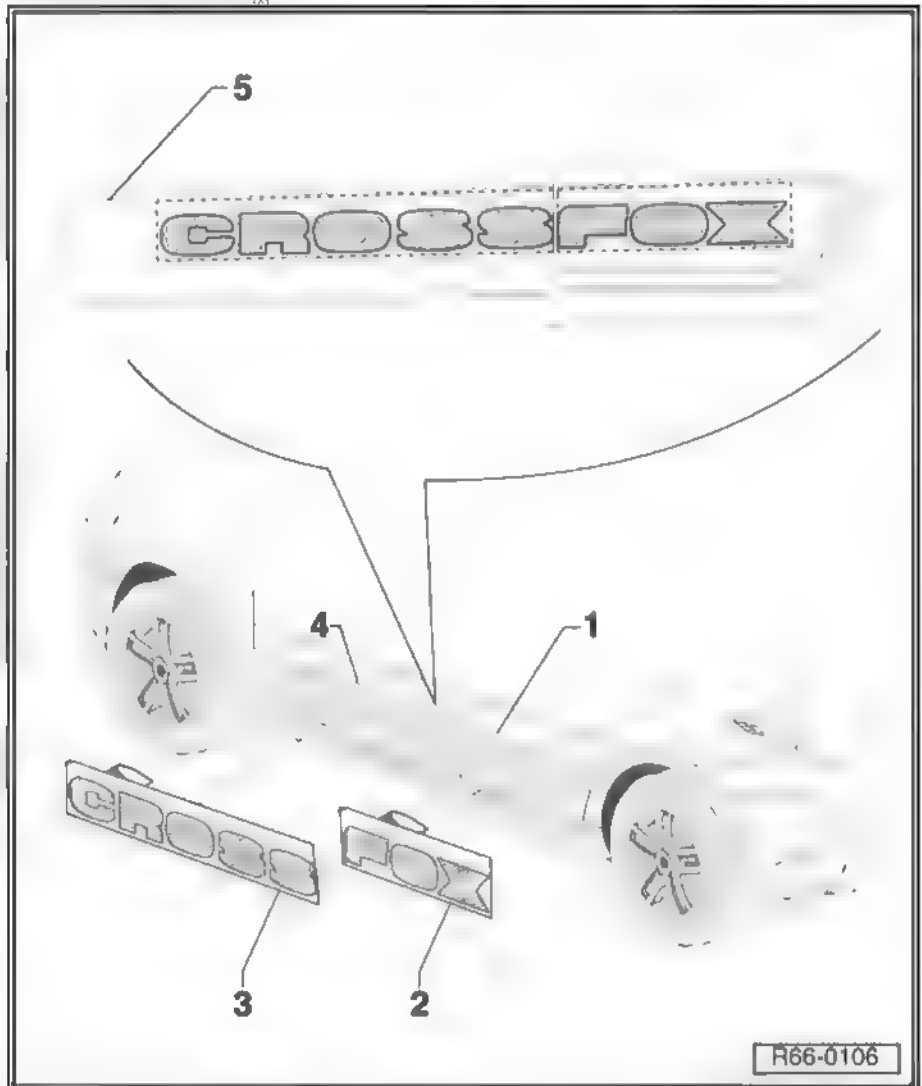
3 - "CROSS" lettering

- ☐ self-adhesive
- ☐ Heat badge using the hot air blower - VAG 1416- prior to removal.
- ☐ Remove badge liner, place the badge plastic foil in relation to the door crease -5-, carefully press in order not to trap air bubbles into the badge, then press it strongly using the pressure roll - 3356- . Operating temperature approx. 20°C.

4 - "CROSS" badge gluing area

- ☐ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

5 - Crease for badge alignment





4.20 CrossFox (2008 ►) side badge - replace



WARNING

- ◆ When handling chemicals follow the safety instructions → *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials → *Electronic Parts Catalogue "ETKA"*

1 - Crease for badge alignment on front door

2 - Rear door badge

- ☐ self-adhesive
- ☐ Rear bumper central protection
- ☐ Heat badge using the hot air blower - VAG 1416- prior to removal.
- ☐ Remove badge liner, place the badge plastic foil in relation to the door crease -6-, carefully press in order not to trap air bubbles into the badge, then press it strongly using the pressure roll - 3356- . Operating temperature approx. 20°C.

3 - Rear passenger door badge gluing area

- ☐ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

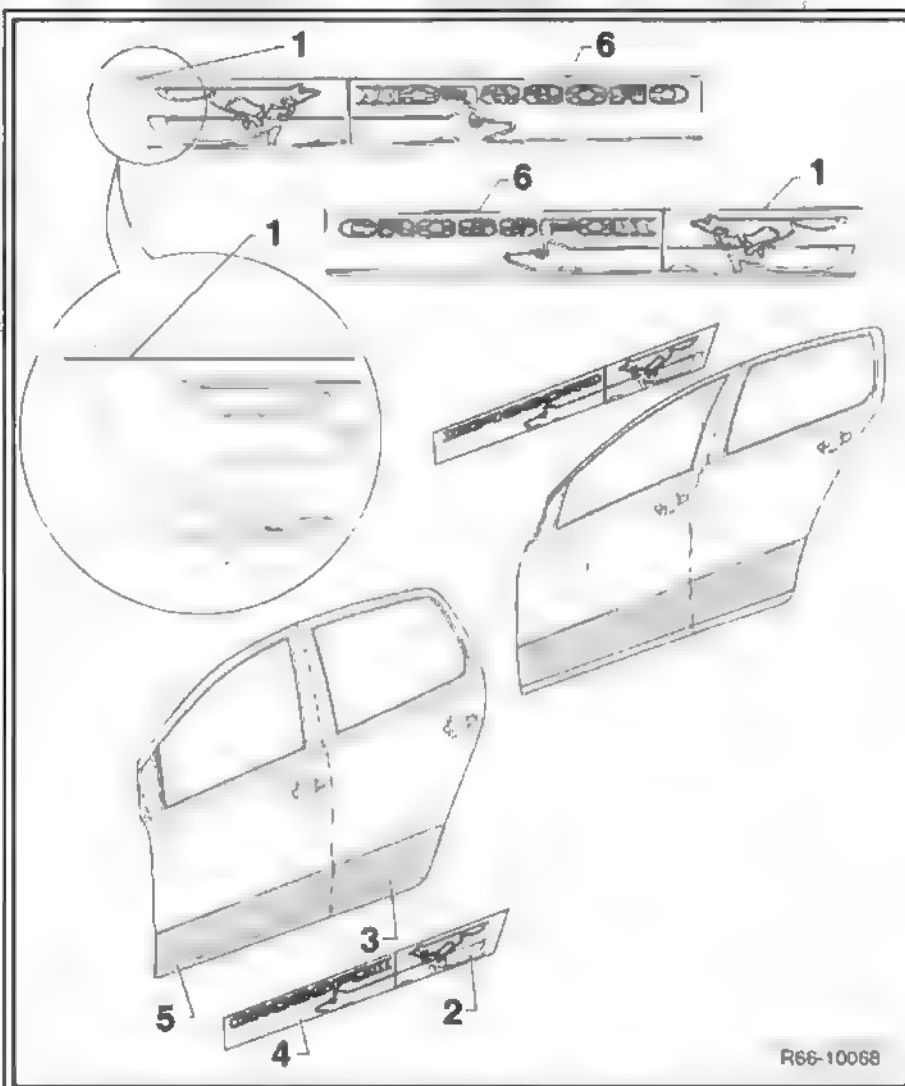
4 - Front door badge

- ☐ self-adhesive
- ☐ Heat badge using the hot air blower - VAG 1416- prior to removal.
- ☐ Remove badge liner, place the badge plastic foil in relation to the door crease -1-, carefully press in order not to trap air bubbles into the badge, then press it strongly using the pressure roll - 3356- . Operating temperature approx. 20°C.

5 - Front door badge gluing area

- ☐ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

6 - Crease for badge alignment on rear passenger door

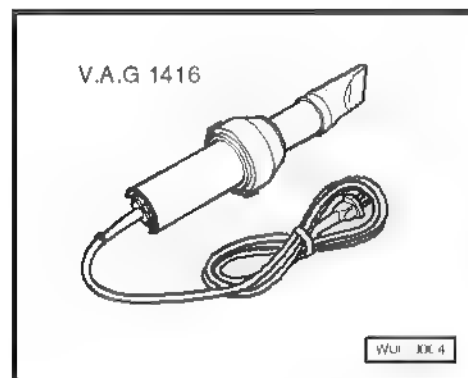




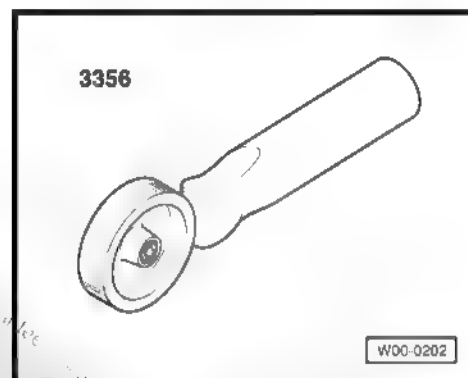
5 Side footboard (CrossFox and Fox Sunrise)

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



5.1 Rear bumper trim - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Rear bumper trim

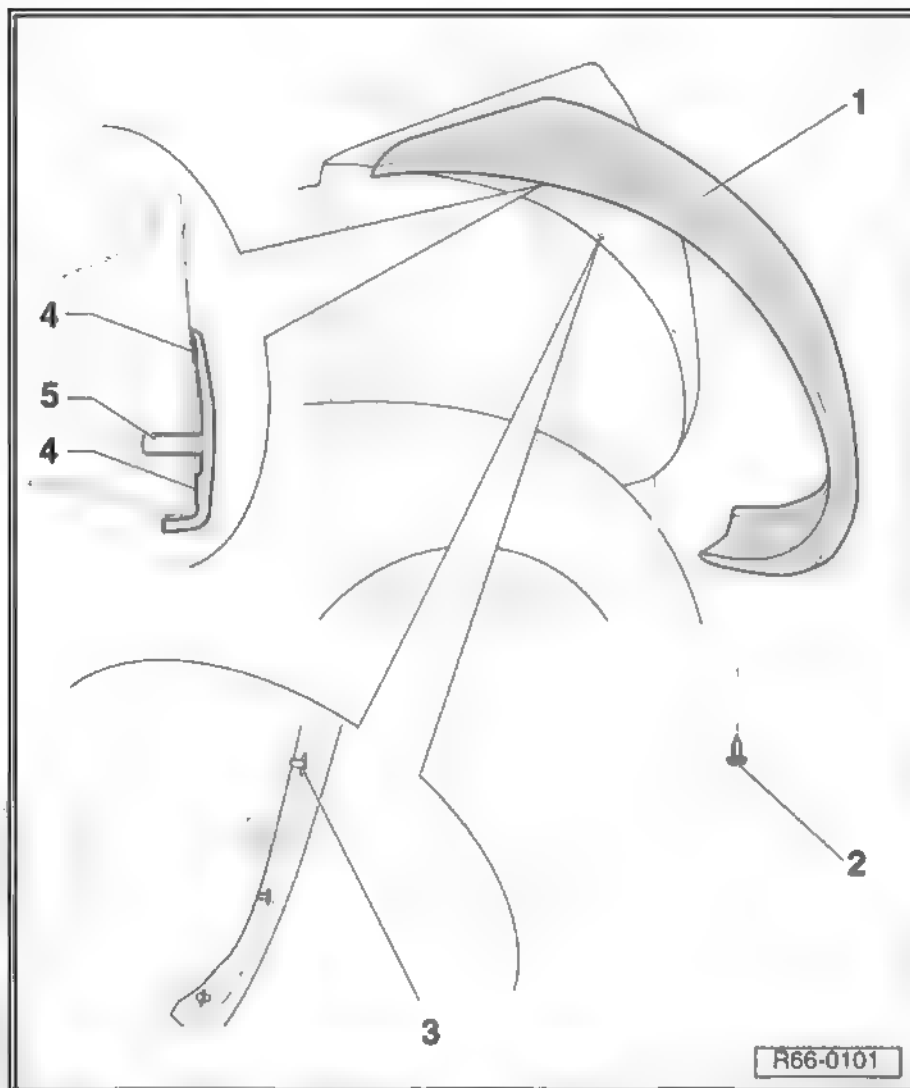
- ☐ Self-adhesive
- ☐ Remove locking washers -3- and screw -2-
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.

2 - Bolt

3 - Locking washer

4 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.



5.2 Rear side panel trim - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



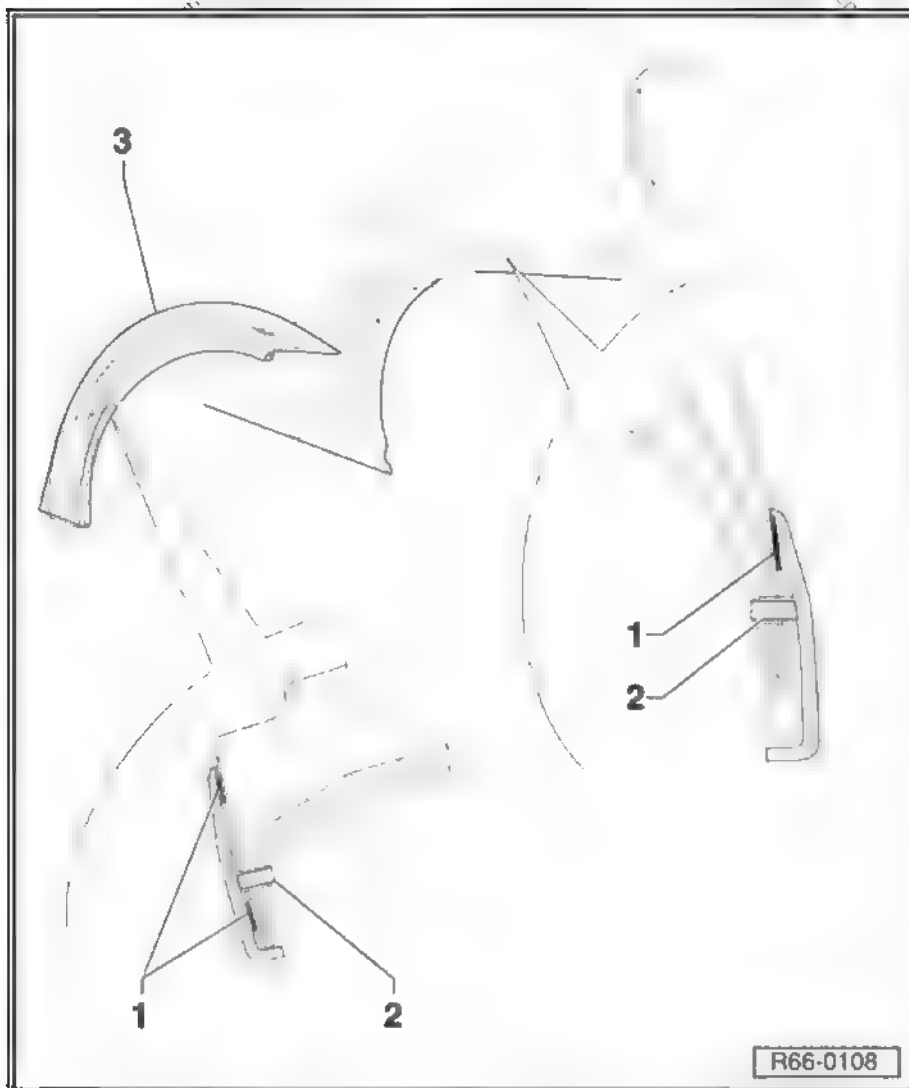
1 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched

2 - Guide pin

3 - Rear side panel trim

- ☐ Self-adhesive
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416-.
- ☐ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.



5.3 Front wing trim - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



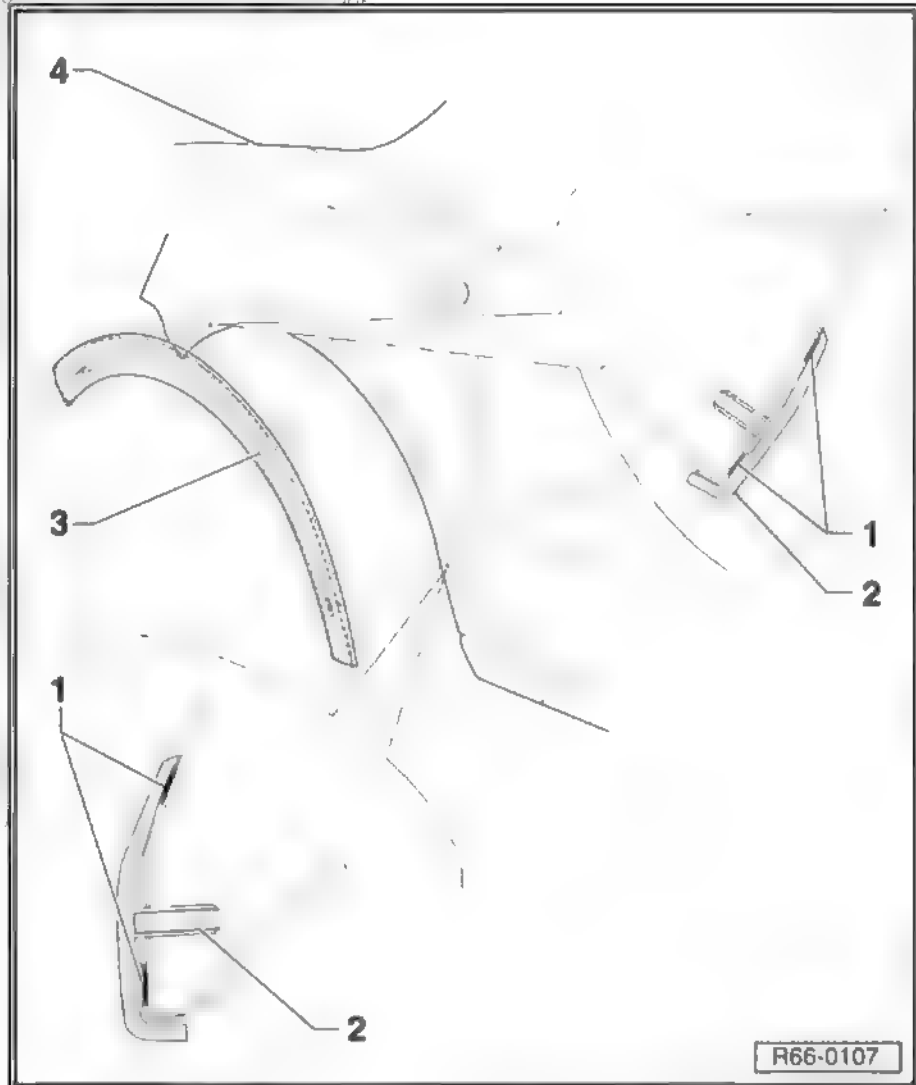
1 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched

2 - Guide pin

3 - Front wing trim

- ☐ Self-adhesive
- ☐ Before removing, you must heat up the trim with the hot air blower - VAG 1416-.
- ☐ Clean the area using adhesive remover - D 002 000 40- , then apply the cleaning solution - D 009 401 04-.
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.



5.4 Side footboard (CrossFox ► 02.06) - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Pop rivet nut

- ☐ To install, use the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422-

2 - Mounting bracket

3 - Bolt

- ☐ Torque: 5 Nm

4 - Bolt

5 - Footboard support (front, central and rear)

6 - Bolt

- ☐ Torque: 25 Nm

7 - Footboard support

8 - Side footboard

- ☐ side footboard and lining are removed together
- ☐ Remove and install
⇒ [page 225](#)

9 - Double-sided adhesive tape

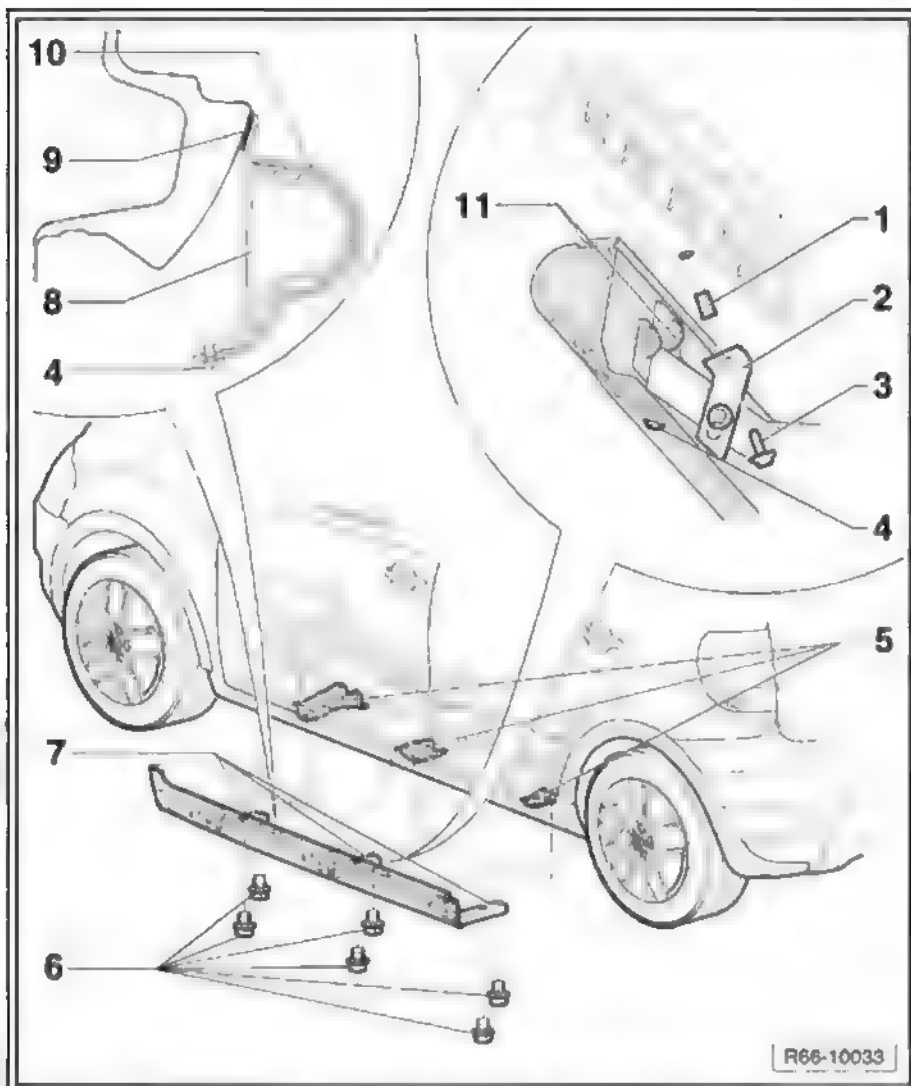
- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

10 - Footboard lining

- ☐ Self-adhesive and fastened by screws -4-.
- ☐ If footboard is removed, lining must be replaced.
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area where the lining shall be glued with adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .
- ☐ Remove adhesive tape liner, place the footboard and lining set. Operating temperature approx. 20°C.

11 - Bolt

- ☐ Torque: 10 Nm

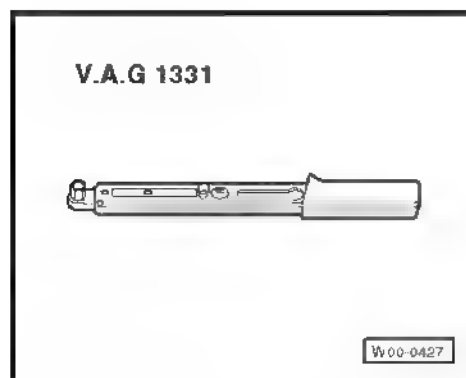


5.5 Side footboard (CrossFox ; ► 02.06) - remove and install

Special tools and workshop equipment required

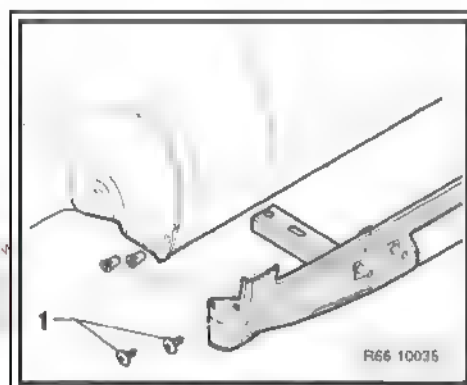


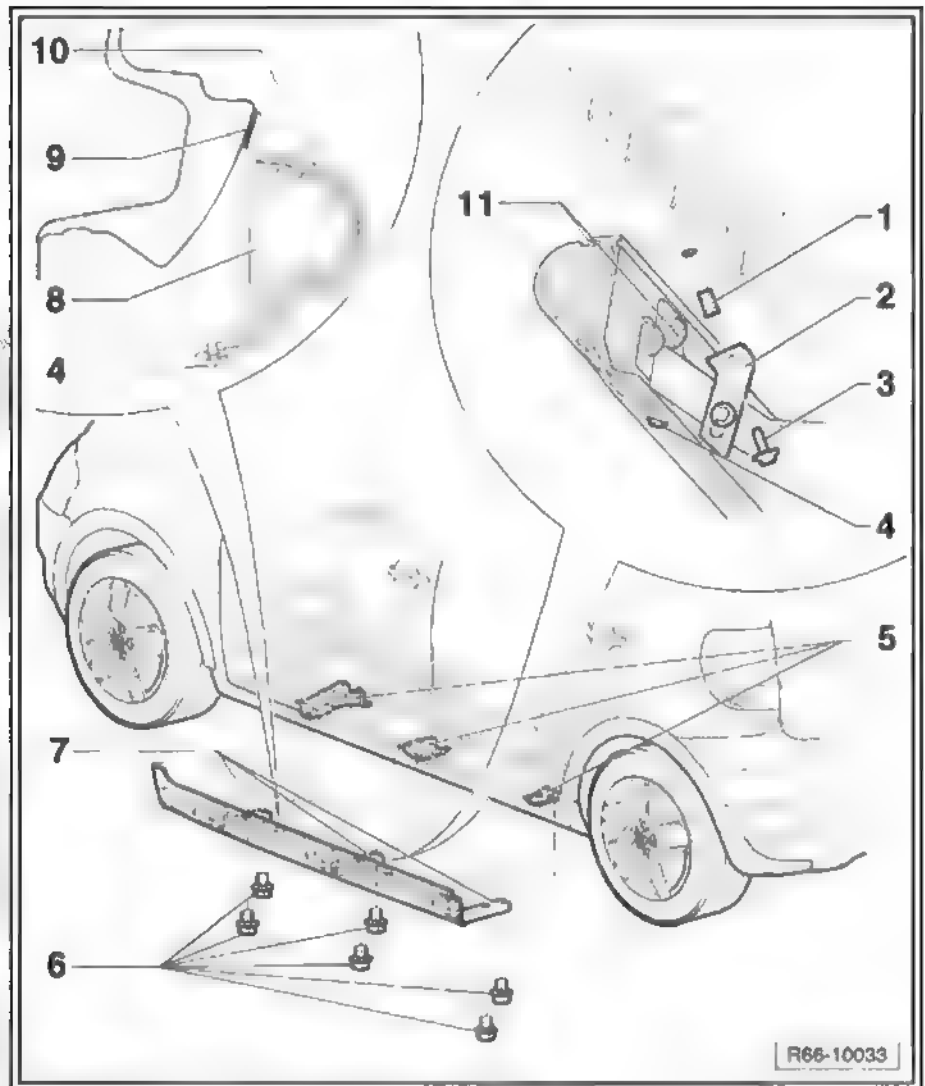
- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



5.5.1 Remove

- Remove side footboard rear lining ⇒ [page 229](#) .
- Remove footboard lining fastening -1- screws.





- Remove the bolt -3-.
- Loosen the bolts -6-.
- Heat footboard lining with the hot air blower - VAG 1416- and detach it from body.
- Remove screws -6- and remove the footboard.
- Remove screws -4- fastening footboard to lining.
- Remove footboard lining by disengaging it from footboard.

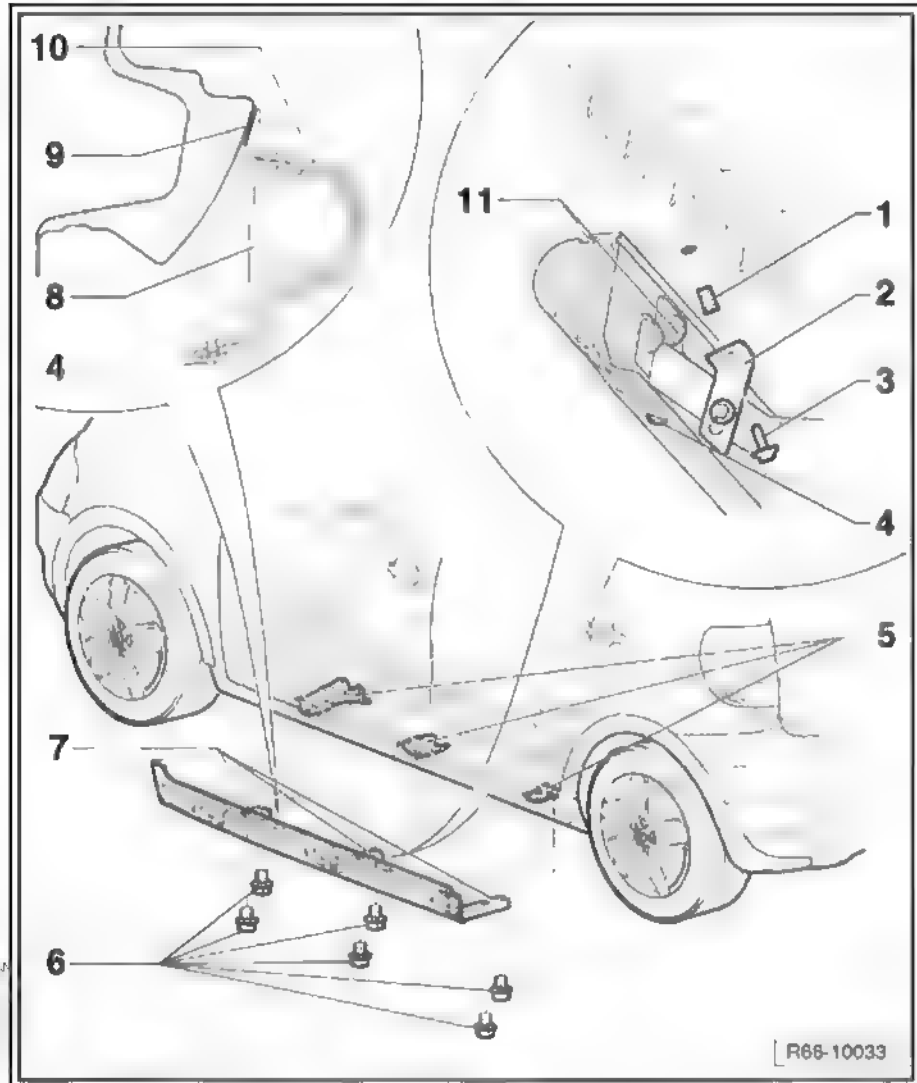
5.5.2 Install



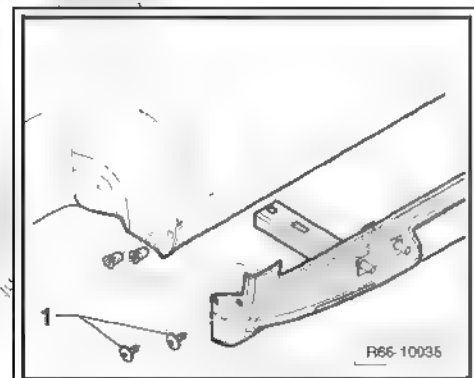
WARNING

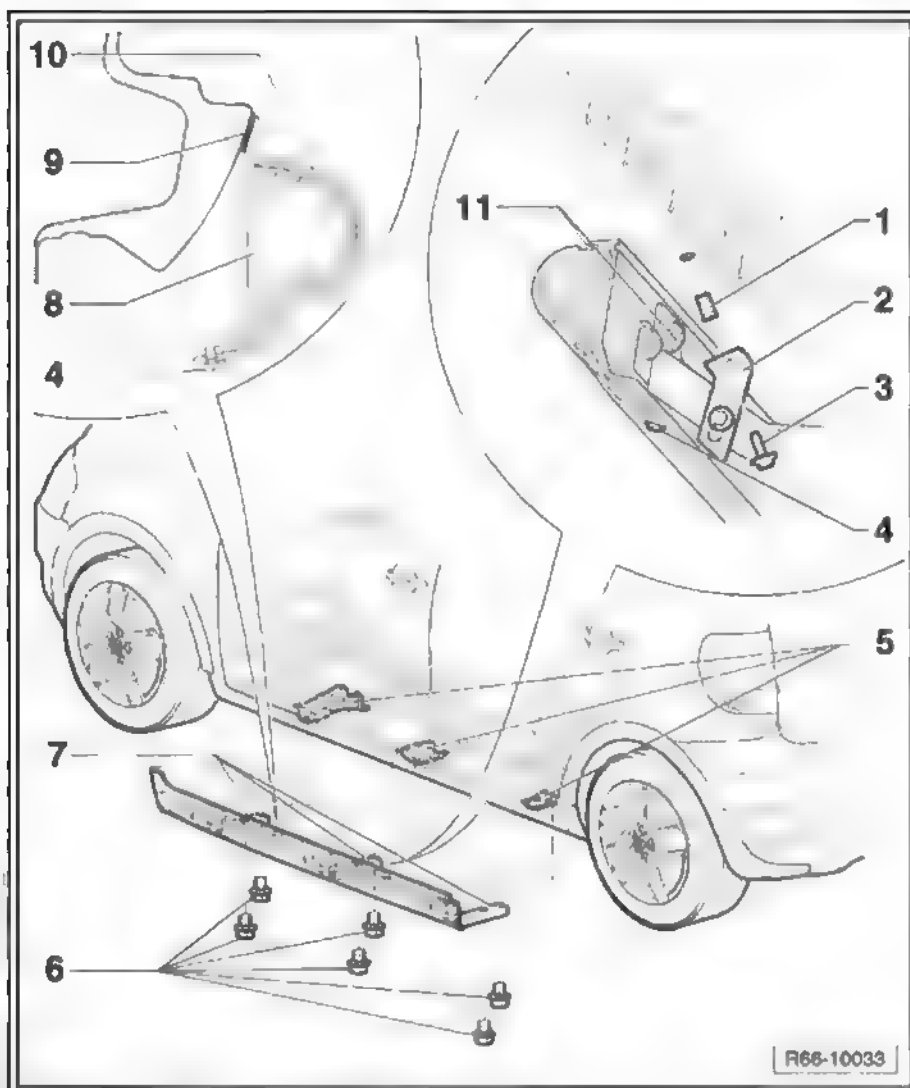
- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual, Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*

- Clean the area where footboard lining shall be glued on body with adhesive remover - D 002 000 10- ,then apply cleaning solution - D 009 401 04-



- Install footboard lining and fasten it with screw -4-.
- Remove adhesive tape liner -9- from footboard lining.
- Place footboard and install screws -6- without tightening them.
- Heat footboard lining with the hot air blower - VAG 1416- and glue it to body.
- Press lining against body with pressure roll - 3356- . Operating temperature approx. 20°C.
- Install side footboard rear lining.
- Install footboard lining fastening -1- screws





– Tighten the screws -6-.

5.6 Side footboard rear lining (CrossFox ; ► 02.06) - general overview of assembly



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Pop rivet nut

- ❑ To install, use the riveted nut applicator POP NUT - VAG 1765B- or riveted nut applicator POP NUT - EQ 7422-

2 - Lining support

3 - Bolt

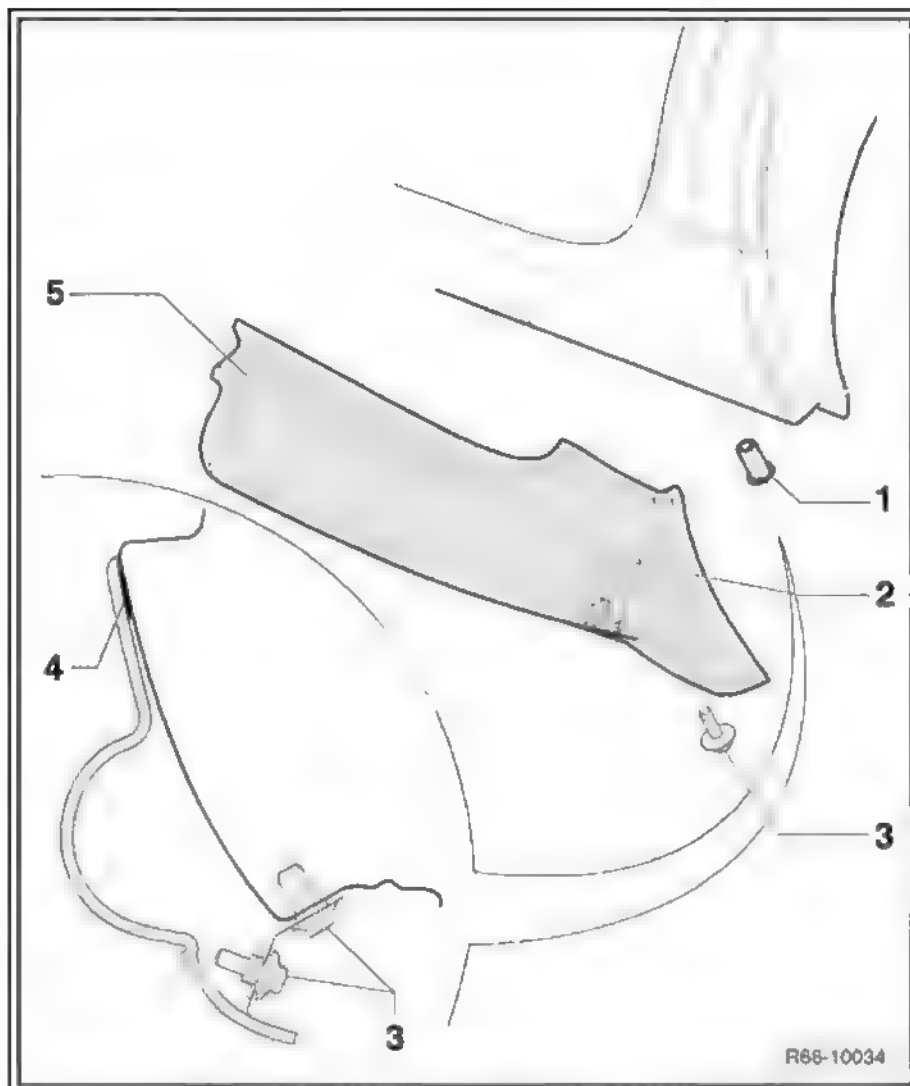
- ❑ Torque: 5 Nm

4 - Double-sided adhesive tape

- ❑ The adhesive tape adhesion area must be completely free of dirt.
- ❑ Under no circumstances should the self-adhesive surface of the tape be touched.

5 - Side footboard rear lining

- ❑ Self-adhesive and fastened by screws.
- ❑ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ❑ Clean the area where lining shall be glued on body with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04- .
- ❑ Operating temperature approx. 20°C.
- ❑ Remove and install
⇒ [page 230](#)



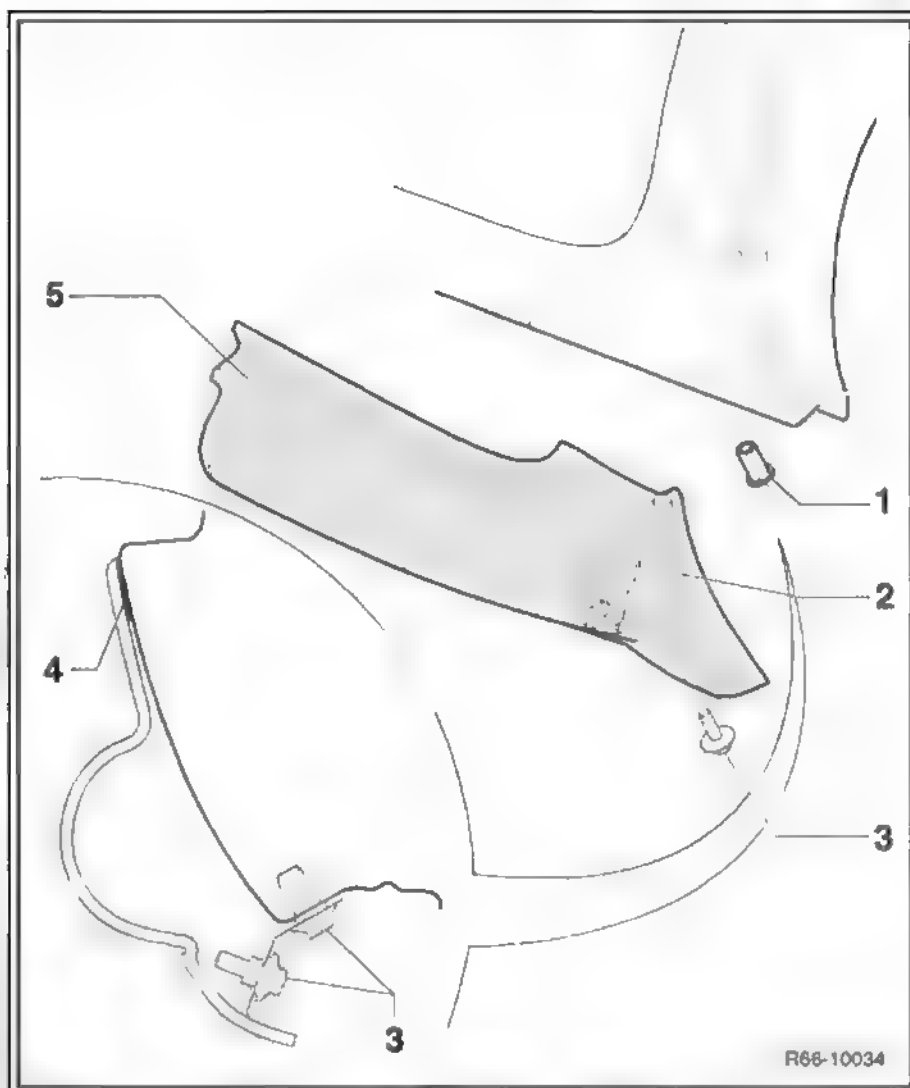
5.7 Side footboard rear lining (CrossFox; ➤ 02.06) - replace

5.7.1 Remove



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*



- Remove the bolt 3-.
- Heat lining with the hot air blower - VAG 1416- .
- Detach lining and remove it.

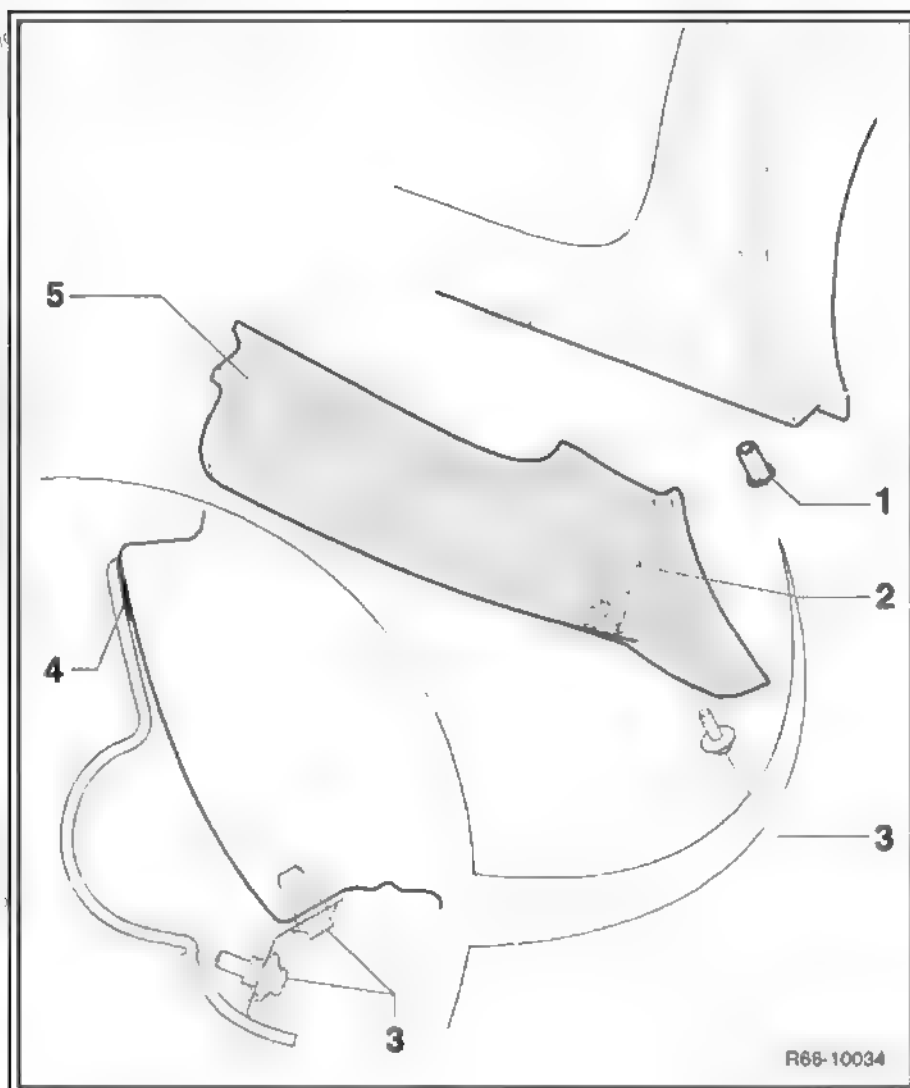
5.7.2 Install



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- Clean the area where lining shall be glued on body with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04- .



- Remove adhesive tape liner -4- .
- Place lining on body.
- Heat lining with the hot air blower - VAG 1416- .
- Glue lining to body and press it with pressure roll - 3356- .
- Install screw -3-.

5.8 Side footboard (CrossFox ; 03.06 ►) - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Side footboard

- ☐ side footboard and lining are removed together
- ☐ Remove and install
→ [page 234](#)

2 - Pop rivet nut

- ☐ To install, use the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422-

3 - Side footboard upper lining

- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area where the lining shall be glued with adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .
- ☐ Operating temperature approx. 20°C.

4 - Nut

- ☐ Torque: 6 Nm

5 - Bolt

6 - Stud

7 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.

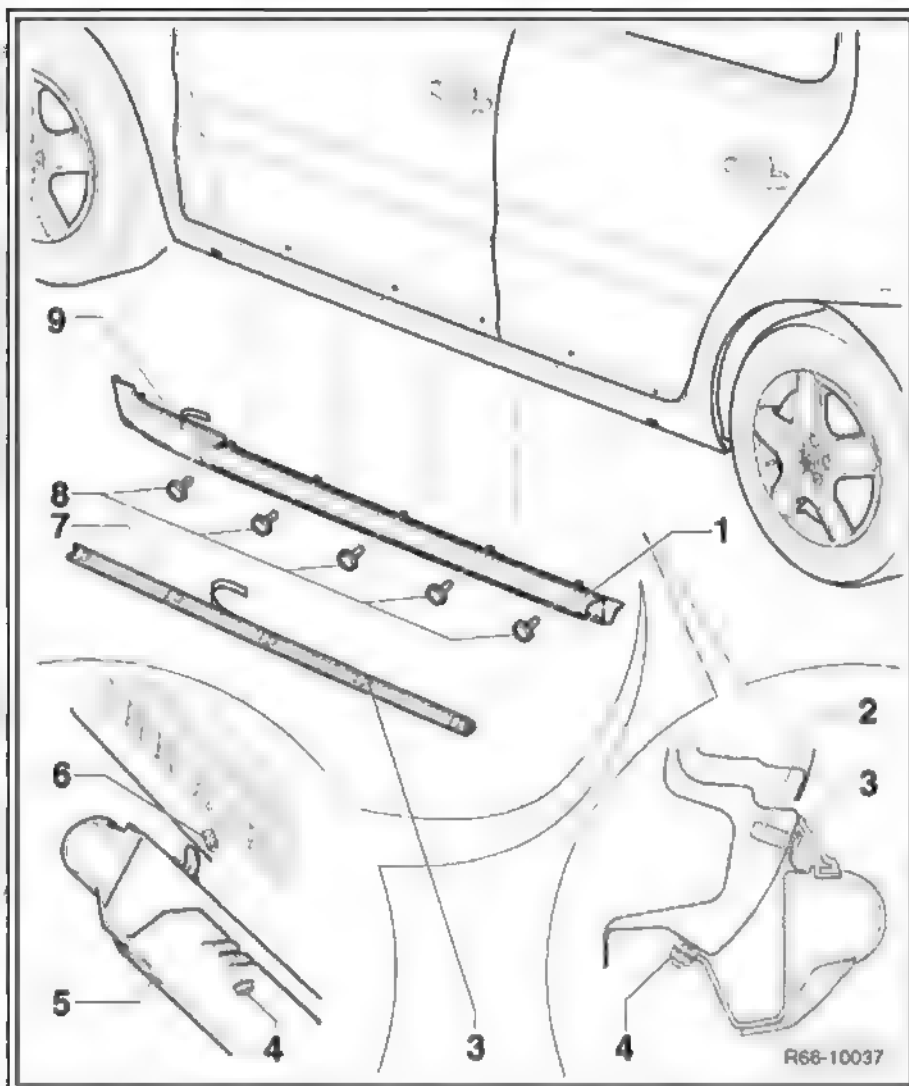
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

8 - Bolt

- ☐ Torque: 6 Nm

9 - Footboard lining

- ☐ Self-adhesive and fastened by screws -4-.
- ☐ If footboard is removed, lining must be replaced.
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area where the lining shall be glued with adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .
- ☐ Operating temperature approx. 20°C.



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5.9 Side footboard (CrossFox ; 03.06 ➤) - assembly overview - continued



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"

1 - Pop rivet nut

- To install, use the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422-

2 - Bolt

- Torque: 6 Nm

3 - Lock pin

4 - Footboard lining

- Self-adhesive and fastened by screws -4-.
- If footboard is removed, lining must be replaced.
- Before removing, you must heat up the lining with the hot air blower - VAG 1416-.
- Clean the area where the lining shall be glued with adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .
- Operating temperature approx. 20°C.

5 - Bolt

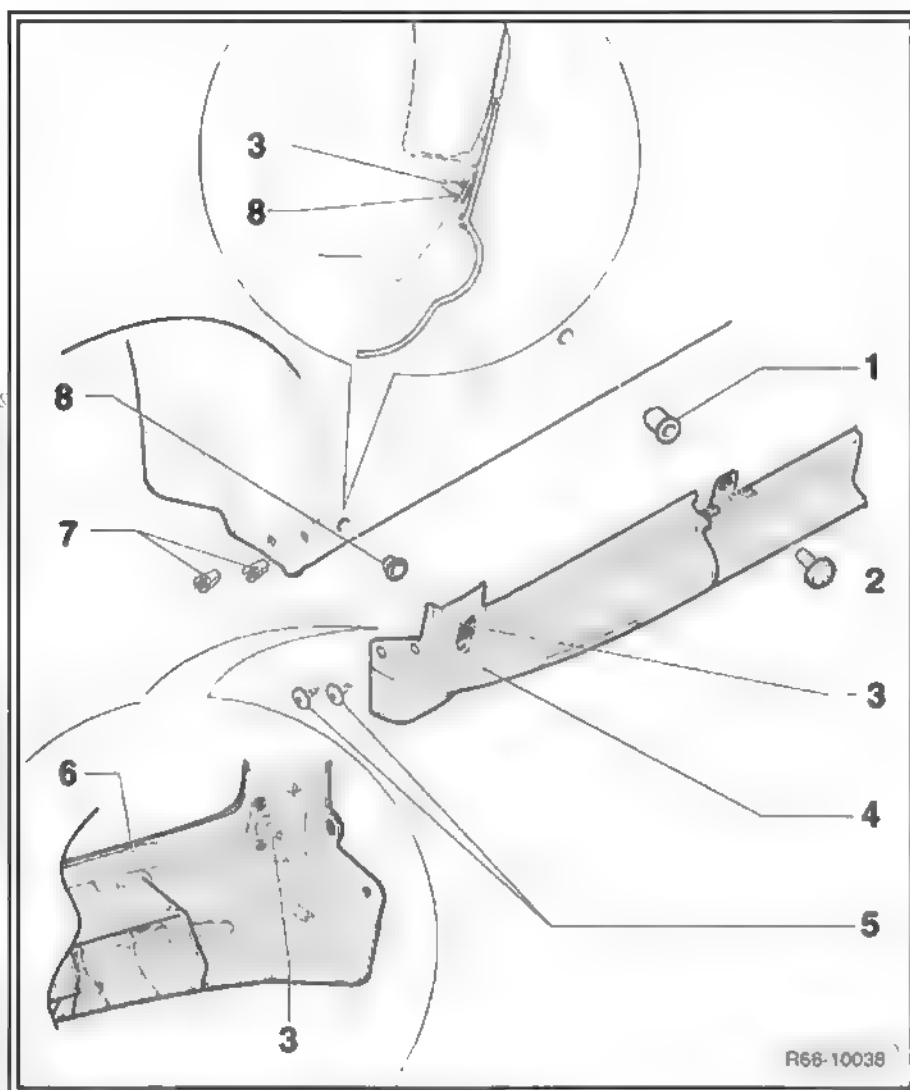
- Torque: 1.5 Nm

6 - Double-sided adhesive tape

- The adhesive tape adhesion area must be completely free of dirt.
- Under no circumstances should the self-adhesive surface of the tape be touched

7 - Bushing

8 - Pressure clamp

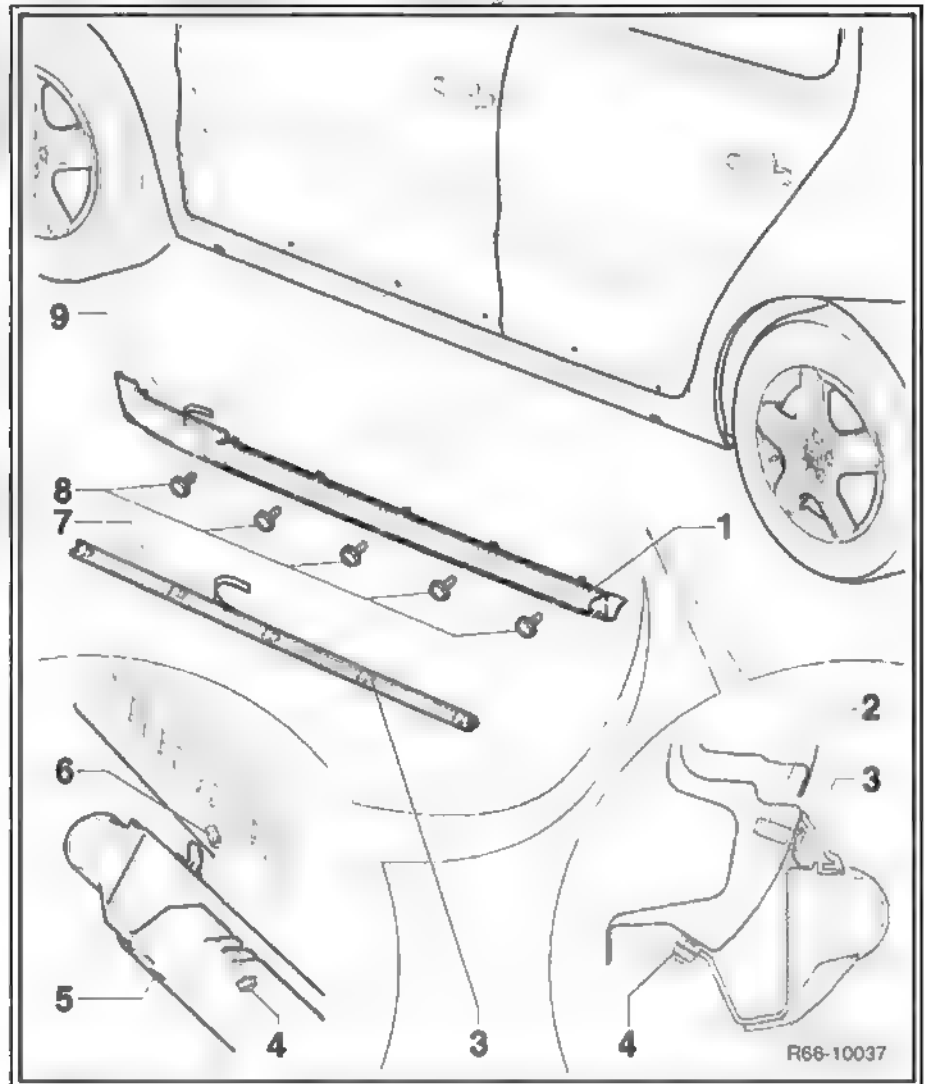




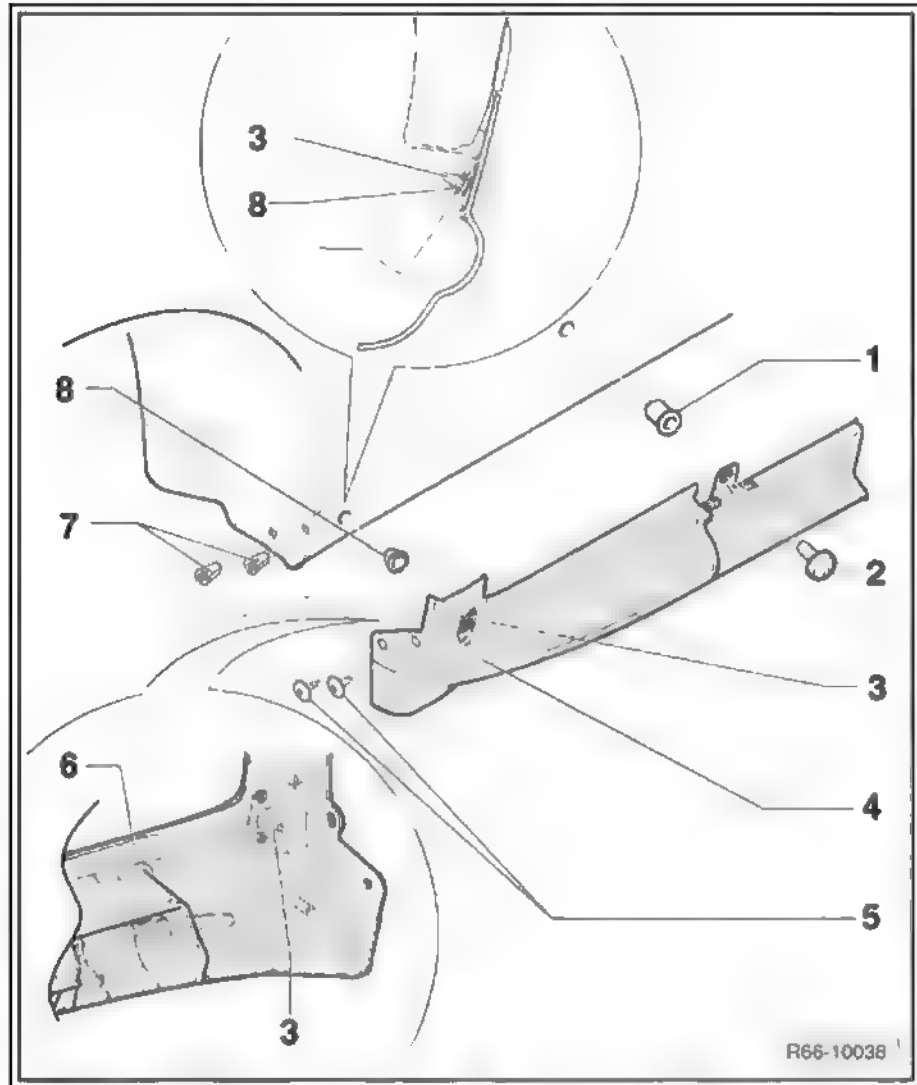
5.10 Side footboard (CrossFox ; 03.06 ➤) - remove and install

5.10.1 Remove

- Remove footboard rear lining



- Detach side footboard upper lining -3- by heating it up with the hot air blower - VAG 1416- .
- Remove nuts -4- and screws -8-. An assistant must keep the footboard suspended until its removal.



- Remove the bolts -5-.
- Remove the bolt -2-.
- Detach footboard lining -4- by heating it up with the hot air blower - VAG 1416- .

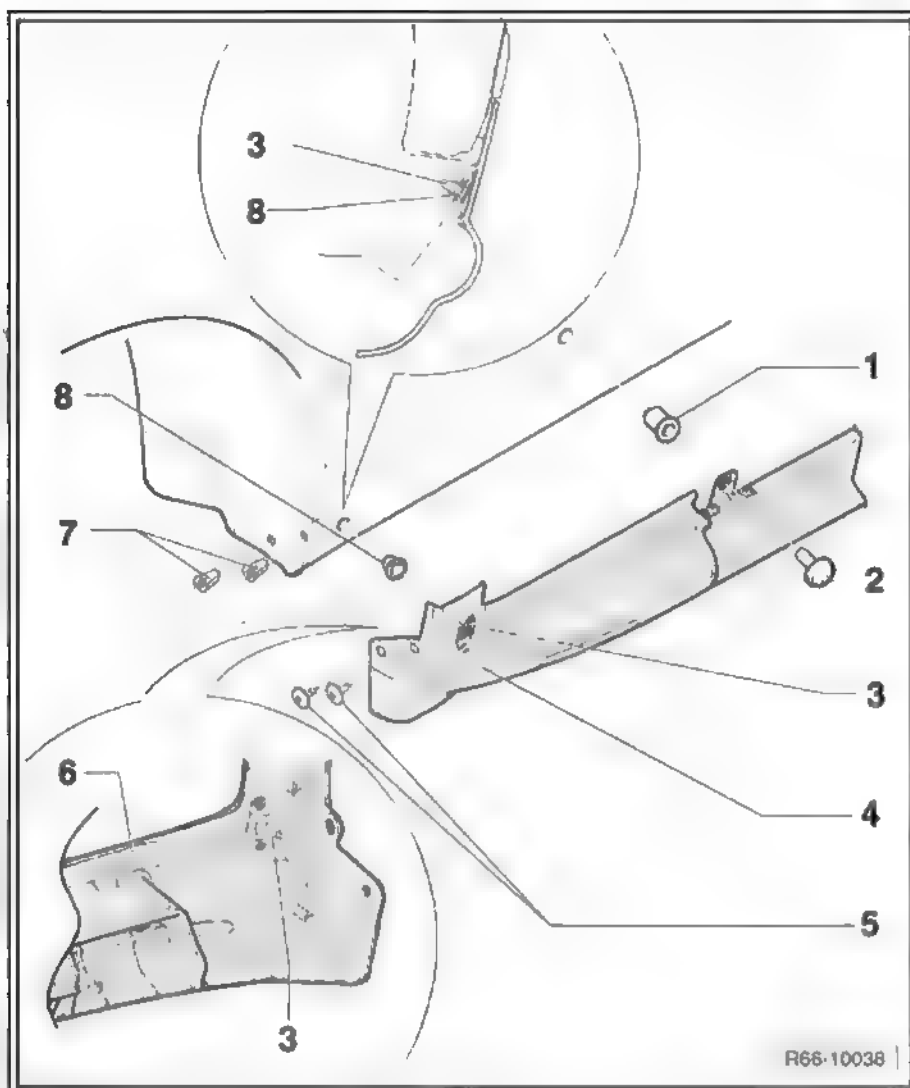
5.10.2 Install



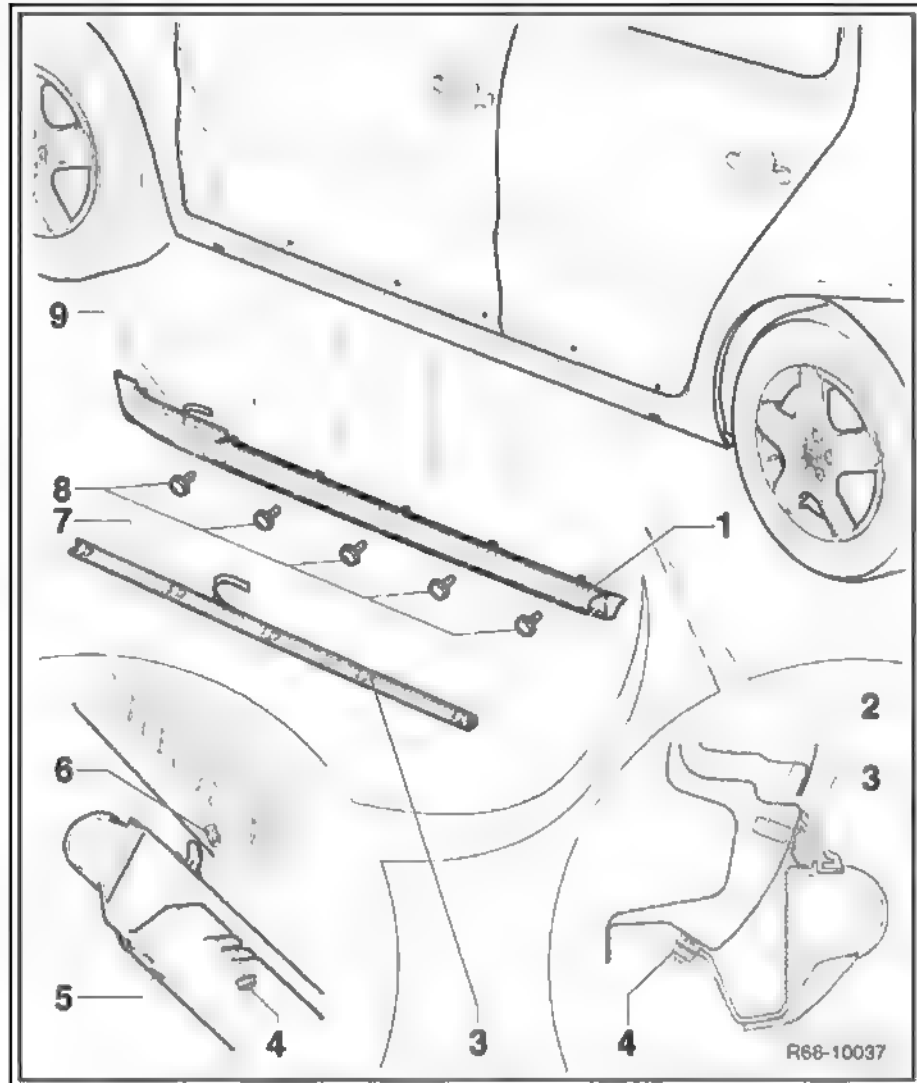
WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- Clean the area where the footboard lining shall be glued on body with adhesive remover - D 002 000 10- , then apply cleaning solution - D 009 401 04- .



- Heat footboard lining -4- with the hot air blower - VAG 1416- .
- Position footboard and install screw -2-.
- Install the screws -5-.



- Install nuts -4- and screws -8-.
- Heat footboard upper lining -3- with the hot air blower - VAG 1416-
- Press footboard upper lining against body with a pressure roll - 3356- .
- Install footboard rear lining.

5.11 Side footboard rear lining (CrossFox ; 03.06 ►) - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Side footboard rear lining

- ☐ Self-adhesive and fastened by screws
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area where lining shall be glued on body with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04- .
- ☐ Operating temperature approx. 20°C.

2 - Nut

- ☐ Torque: 6 Nm

3 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

4 - Bolt

- ☐ Torque: 3 Nm

5 - Stud

6 - Nut

- ☐ Torque: 6 Nm

7 - Lining support

8 - Pressure clamp

9 - Lock pin

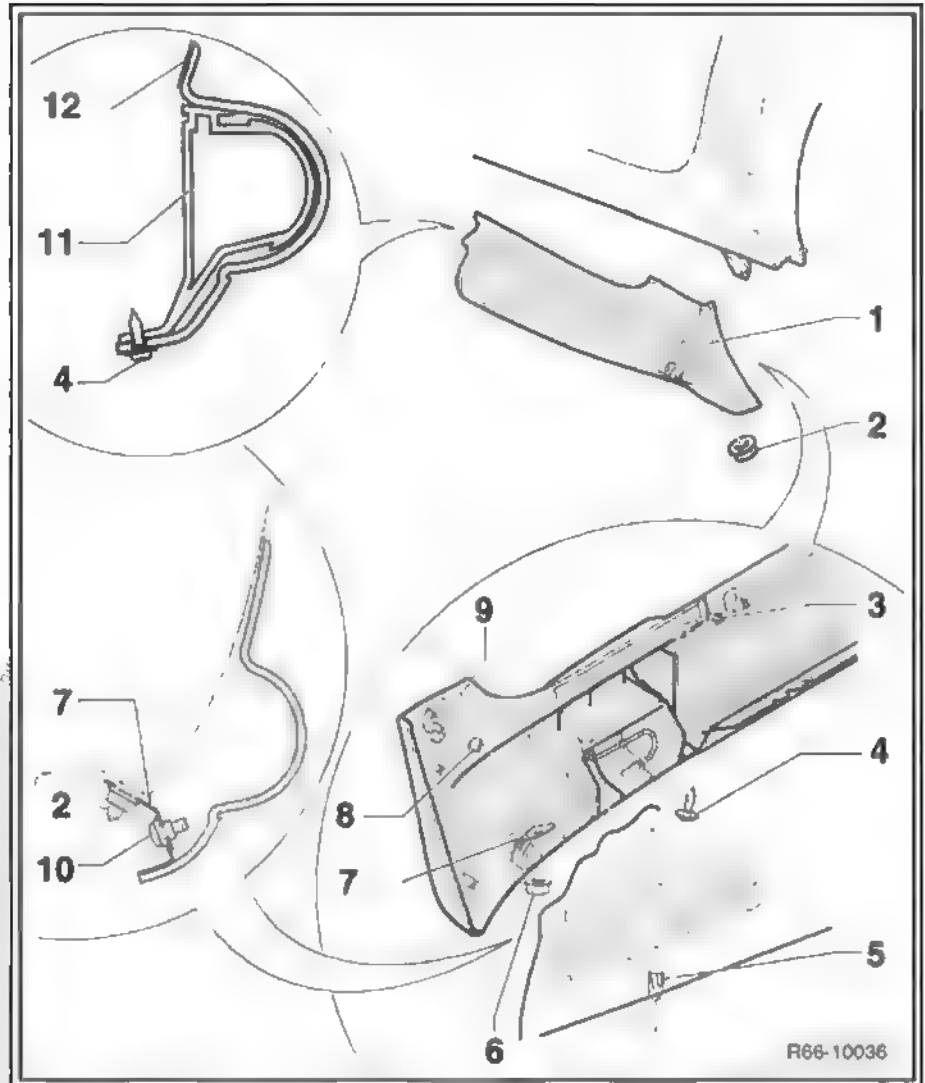
10 - Bolt

- ☐ Torque: 5 Nm

11 - Side footboard

12 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched





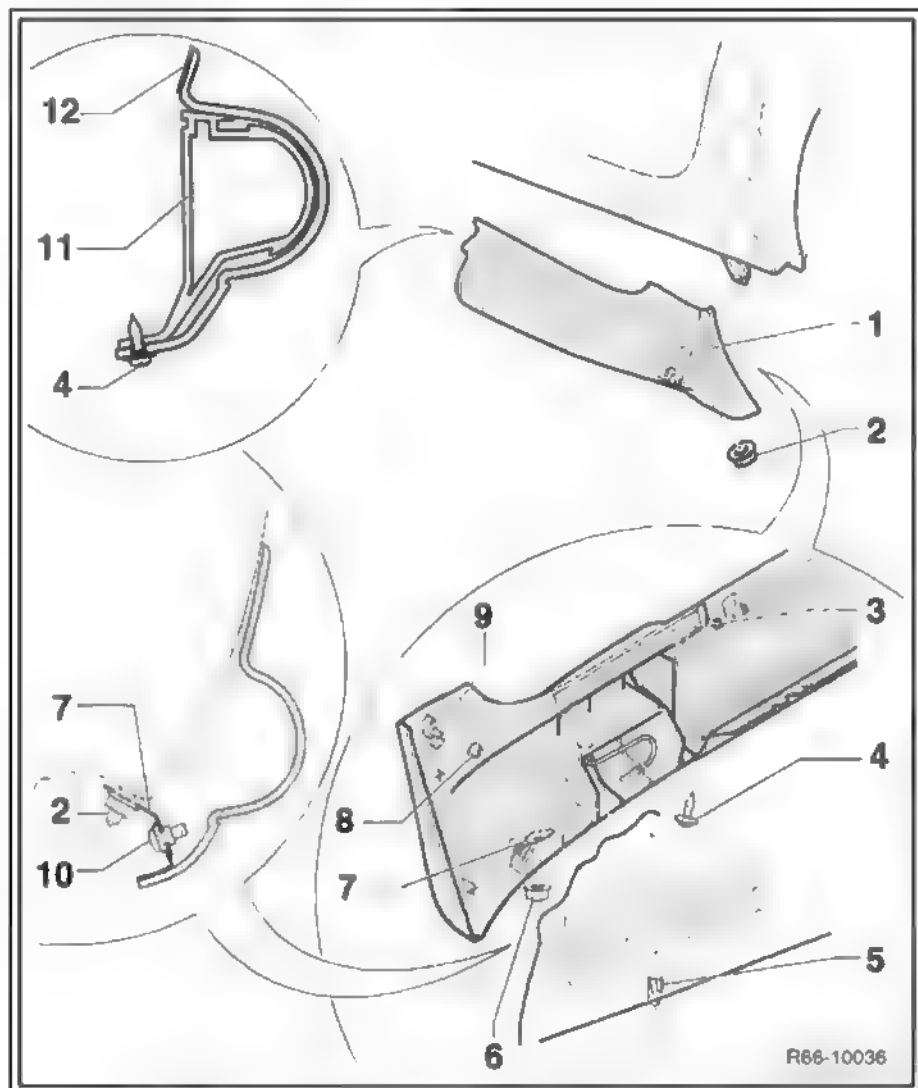
5.12 Side footboard rear lining (Crossfox ; 03.06 ►) - replace

5.12.1 Remove



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*



- Remove screw -4- and nut -6-
- Detach side footboard rear lining -1- by heating it up with the hot air blower - VAG 1416- .



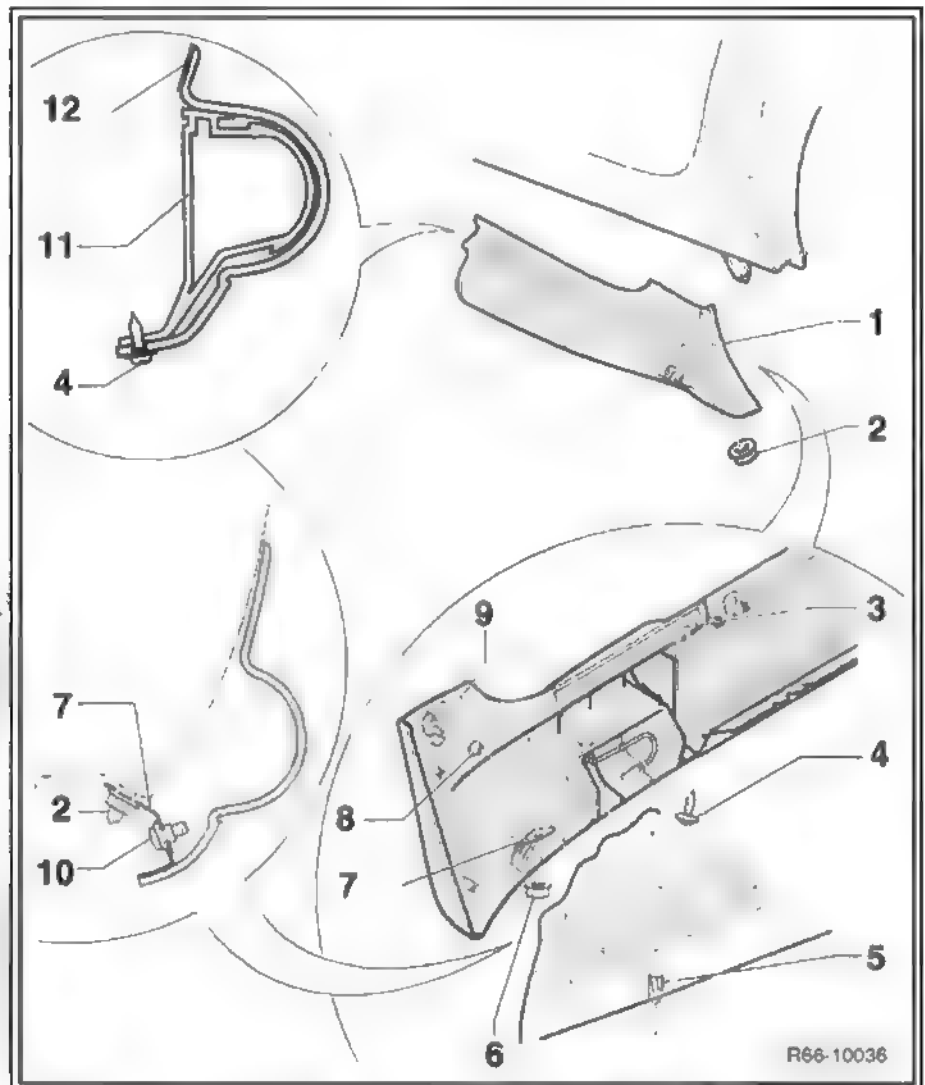
5.12.2 Install



WARNING

- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*

- Clean the body area where the footboard rear lining will be glued to the body with adhesive remover - D 002 000 10- and then apply the cleaning solution - D 009 401 04- .



- Heat up the footboard rear lining -1- with the hot air blower - VAG 1416-
- Place rear lining and install screw -4- and nut -6-.
- Press footboard rear lining against body with a pressure roll - 3356- .



6 External rear-view mirror

6.1 External rear-view mirror - assembly overview

1 - Finishing cover

2 - Clip

☐ 2 units

3 - Bushing

4 - Bolt

☐ 3 units

☐ Torque: 2.5 Nm

5 - Nut

6 - Internal control

7 - Bushing

8 - Mirror glass

☐ fitted in for both versions
(manual and electric
command)

☐ Remove and install
⇒ [page 245](#)

9 - Bushing

10 - Connector

☐ version with electric
command

11 - Activation support

☐ version with manual
command

12 - Blind rivet

☐ 2 units

☐ version with manual
command

13 - Clip

☐ 2 units

14 - Mirror fastening cover

☐ version with manual command

☐ with opening for activation rod

15 - Operating button

☐ version with manual command

☐ fitted to operating rod

16 - Bolt

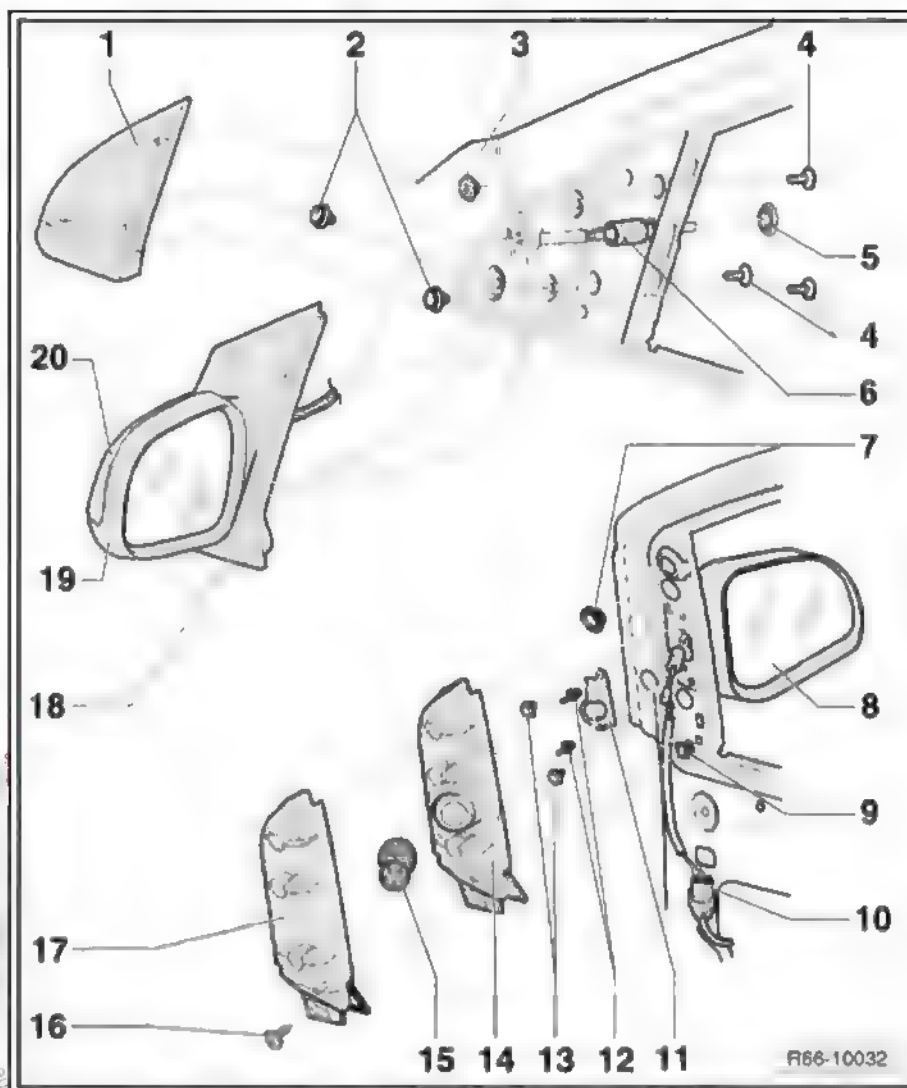
☐ Torque: 2.5 Nm

17 - Mirror fastening cover

☐ version with electric command

18 - External rear-view mirror

☐ Remove and install ⇒ [page 243](#)





19 - Mirror frame

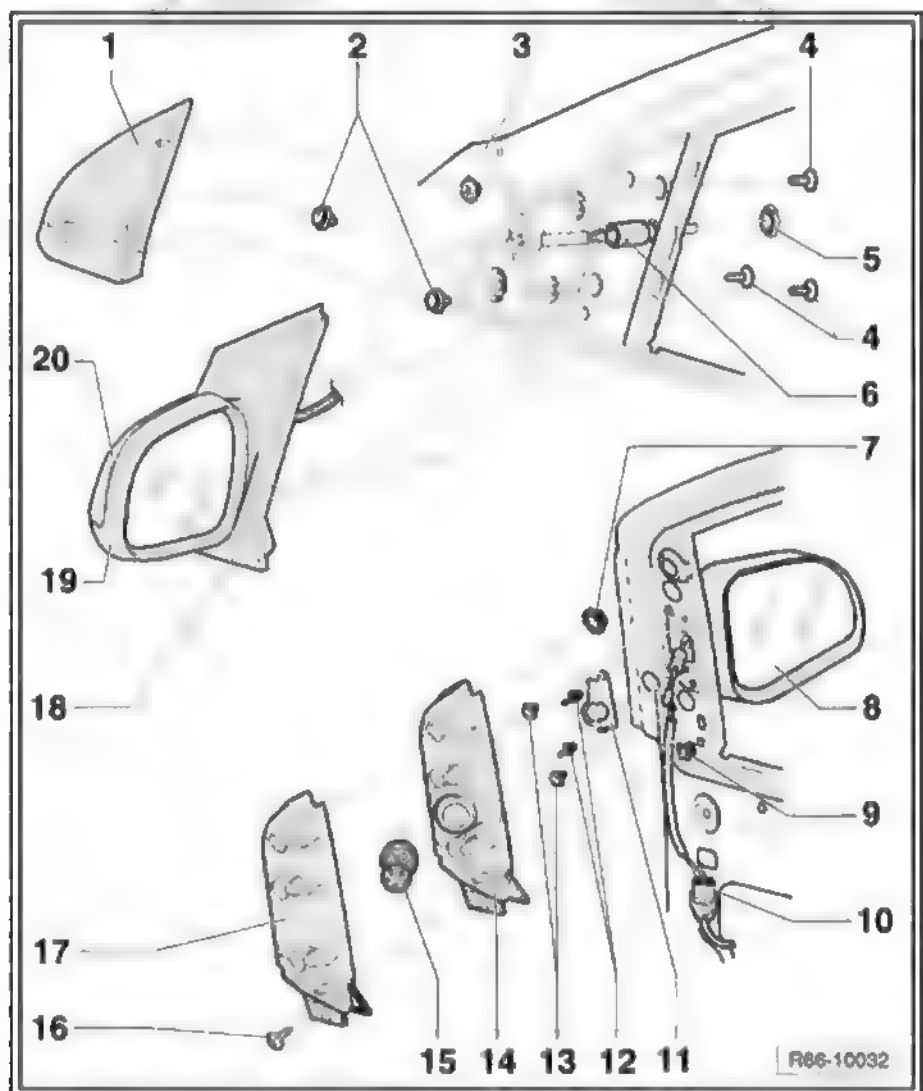
20 - Mirror covering

□ remove → [page 244](#)

6.2 Exterior rear-view mirror - remove and install

Remove

- Remove the door lining → General body repairs, interior, Rep. gr. 70 ; Lining / insulation



- Remove cover cap (with manual control) -14- or (with electric control) -17-.
- ◆ For version with manual control, remove the activation button -15- and remove nut -5-.
- ◆ For version with electric control, disconnect connector -10-.
- Remove the screws -4- and remove the exterior mirror -18-.



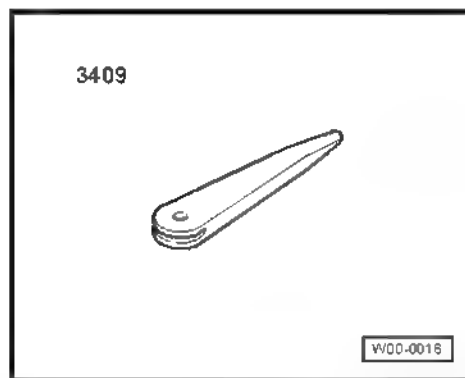
Install

- Installation is performed in the reverse sequence to the removal

6.3 Mirror glass - remove and install

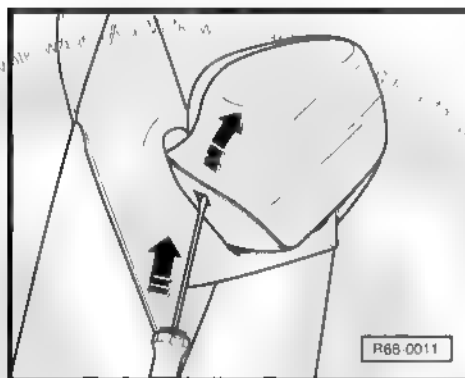
Special tools and workshop equipment required

- ◆ Wedge - 3409-



6.3.1 Remove

- Fold rear-view mirror backwards.
- Insert a screwdriver or similar in the mirror base support joint opening to be able to unlock the fitting shoulder on mirror cover.
- Use just enough pressure over the fitting shoulder with the screwdriver in -direction of arrow- so as to prevent damage to it, while removing mirror base support mirror cover by using a wedge - 3409-. Disengage cover by moving it towards -arrow-.



Caution

The cover is made of ABS, and the mirror case is made of ASA (Styrol Acrylnitril modified by Acrilester). Therefore, it is sensitive to lock breakages.

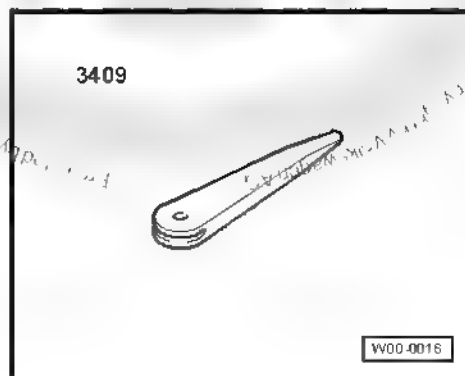
6.3.2 Install

- Press the covering and first fit it to the upper section of the case, and then to the lower section.

6.4 Mirror frame - remove and install

Special tools and workshop equipment required

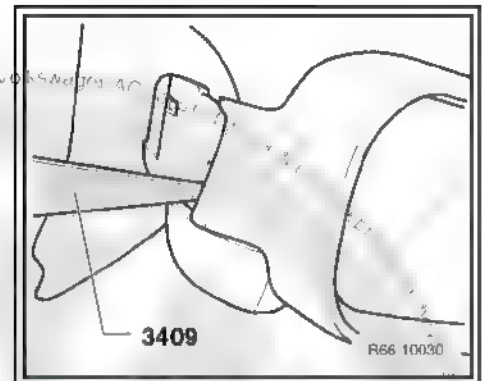
- ◆ Wedge - 3409-





Remove

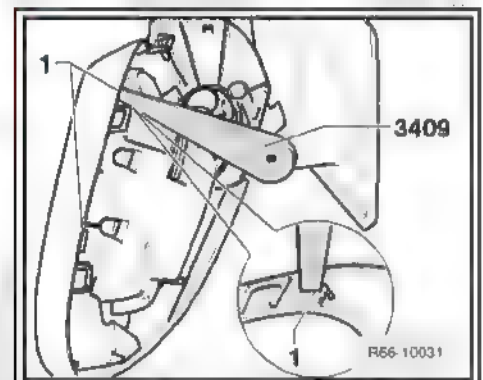
- Tilt mirror in opposite direction of vehicle movement.
- Remove mirror cover ➔ [page 244](#) .



- Unlock frame with a wedge - 3409- .
- Disengage frame locks -1- with a wedge - 3409- .
- Disengage and remove the frame.

Install

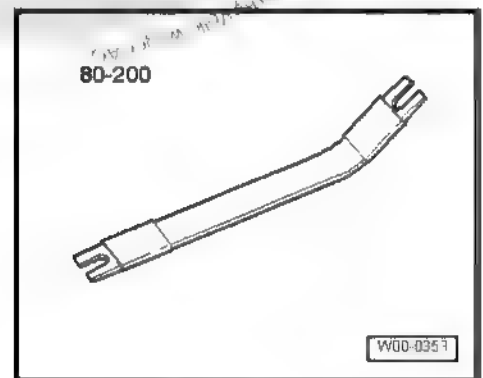
- Installation is performed in the reverse sequence to the removal.



6.5 Mirror glass - remove and install

Special tools and workshop equipment required

- ◆ Removal lever - 80-200-



Remove

- Remove mirror cover ➔ [page 244](#) .



- Unlock upper fitting shoulders with a screwdriver or similar through openings -arrows- in the mirror base support.
- To avoid damages to the fitting shoulders, make only sufficient pressure on the fitting shoulders with the screwdriver in -direction of the arrow-.
- Concurrently, press mirror glass with a ejector lever - 80-200- , first upward, then below the mirror base support; in this case protect the base support against damage (for instance, with a cotton stripe).
- For heated mirrors, disconnect mirror glass connectors

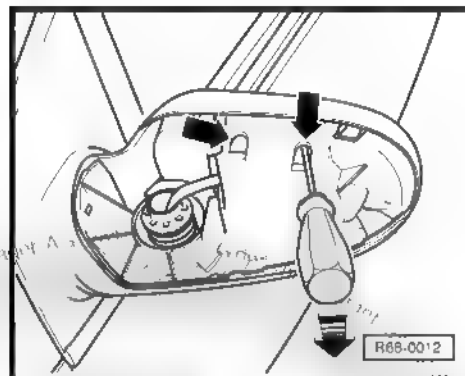
Install

- Connect electric connections in heated mirrors.
- Place and press the mirror glass with the guide pins to the housings.



DANGER!

Press only onto the glass centre. Always wear safety gloves.



- Install the mirror cover.

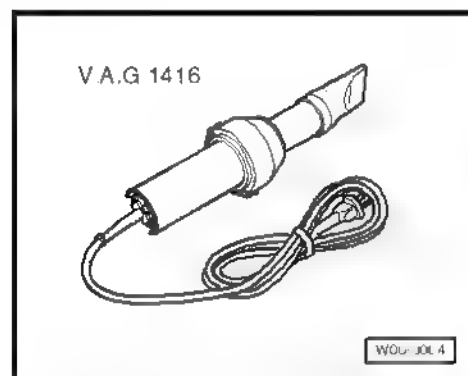


7 Side trims

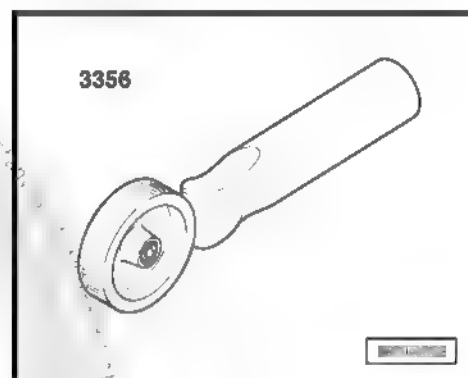
7.1 Side trims (Fox - 2-door) - replace

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



Side trims



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Side trim / rear door

- ☐ self-adhesive
- ☐ Dimension "a" = 8 mm
- ☐ Remove

– Unglue the trim with the hot air blower - VAG 1416-, for easing the removal.

– Remove all dirt and oiliness.

– Remove adhesive residues with the adhesive remover - D 002 000 10- and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

☐ Install

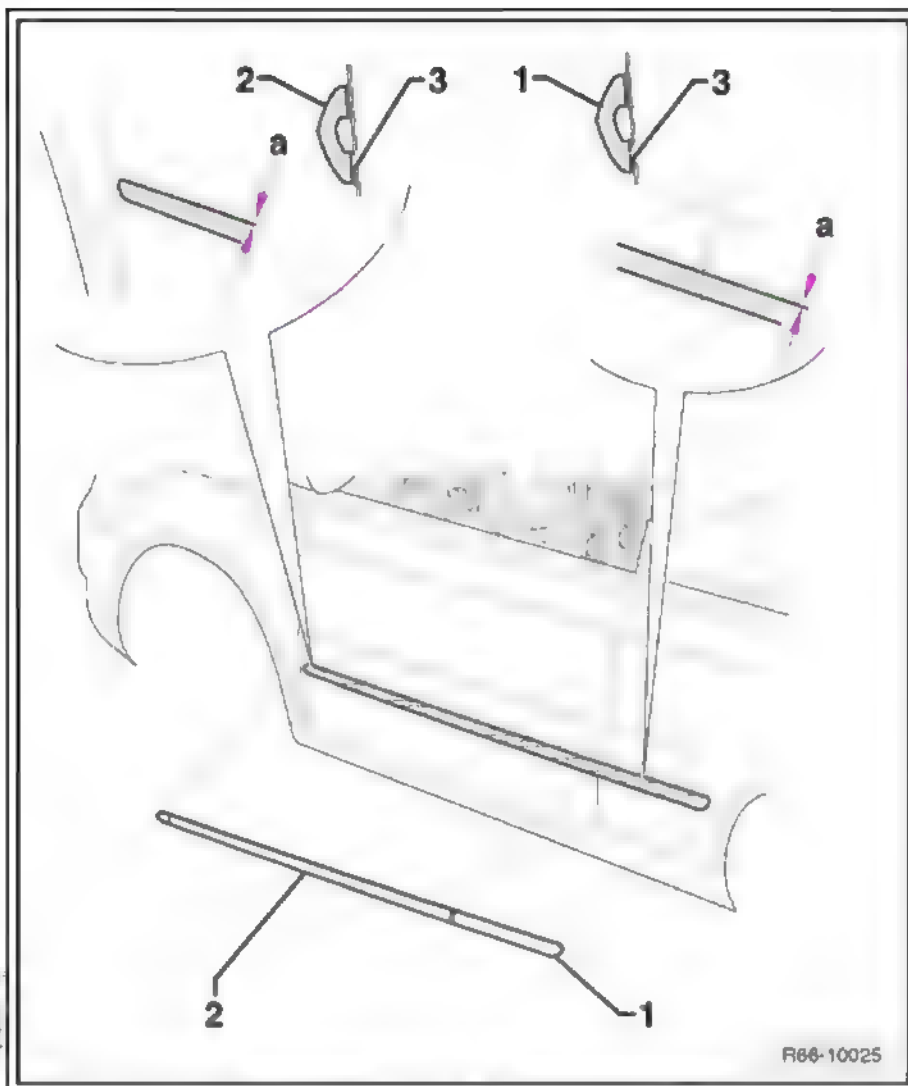
– Heat up trim and surface with hot air blower - VAG 1416- to make installation easier.

– Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

Respect dimension "a".



2 - Front door trim

- ☐ self-adhesive
- ☐ Dimension "a" = 8 mm
- ☐ Remove

– Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.

– Remove all dirt and oiliness.

– Remove adhesive residues with adhesive remover - D 002 000 10- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

☐ Install

– Heat up trim and surface with hot air blower - VAG 1416- to make installation easier.

– Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

♦ *Operating temperature approx. 20°C.*

♦ *Respect dimension "a".*

3 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.



- ☐ Under no circumstances should the self-adhesive surface of the tape be touched

7.2 External longitudinal member lower lining (Fox 09.06 ►) - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

1 - Pressure clamp

2 - Lock pin

3 - Bolt

4 - Access cover to jack support

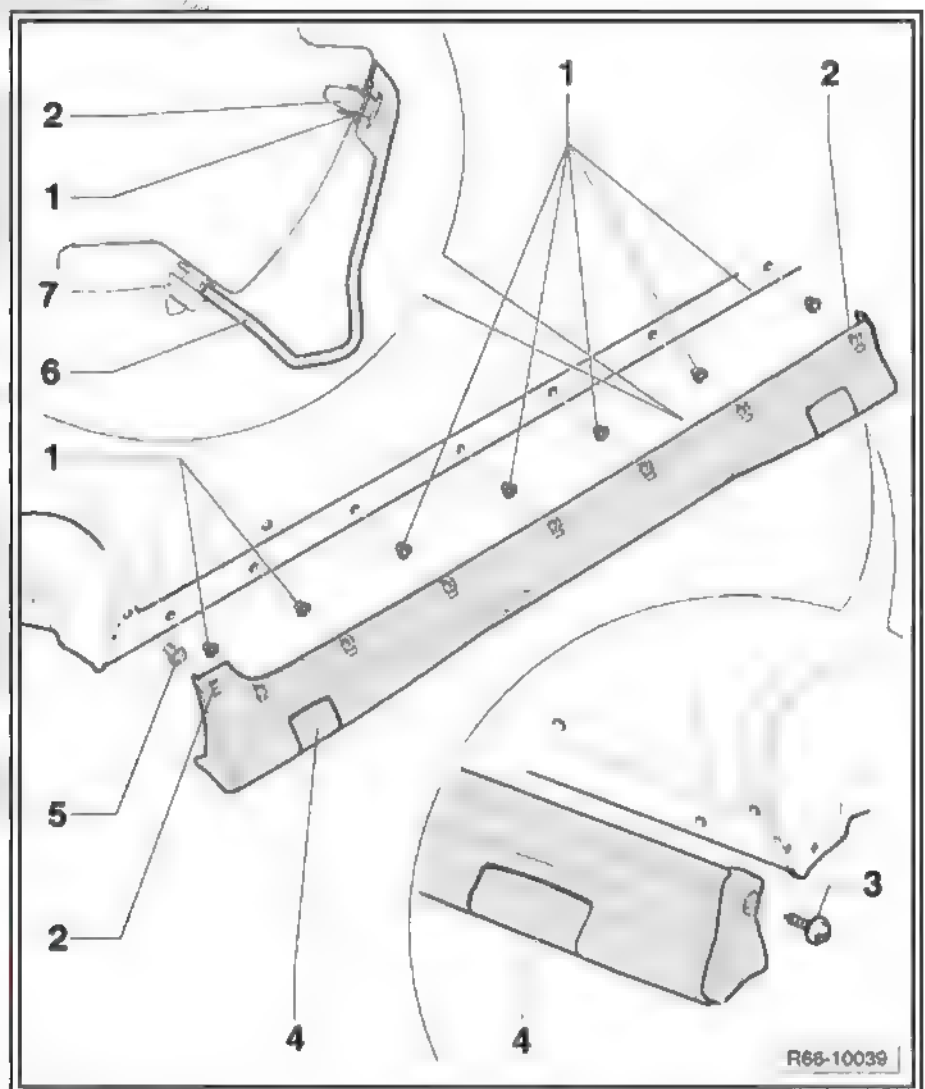
5 - Clip

6 - Lower longitudinal member external lining

- ☐ Self-adhesive, fastened by screws and clamps.
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416-.
- ☐ Clean the area where lining shall be glued on body with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04-.
- ☐ Operating temperature approx. 20°C.
- ☐ Remove and install ⇒ [page 249](#)

7 - Nut

- ☐ Torque: 1.5 Nm

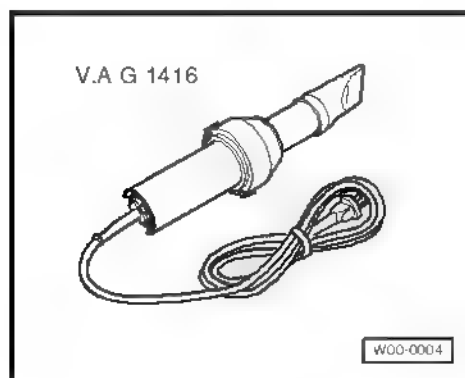


7.3 External longitudinal member lower lining (Fox 09.06 ►) - remove and install

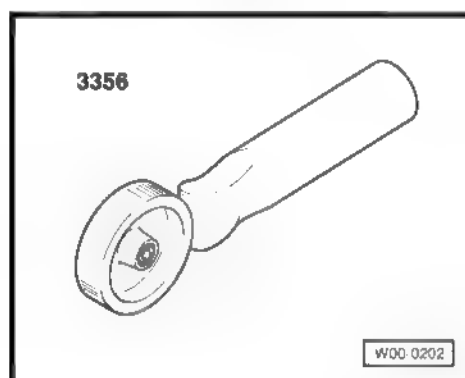
Special tools and workshop equipment required



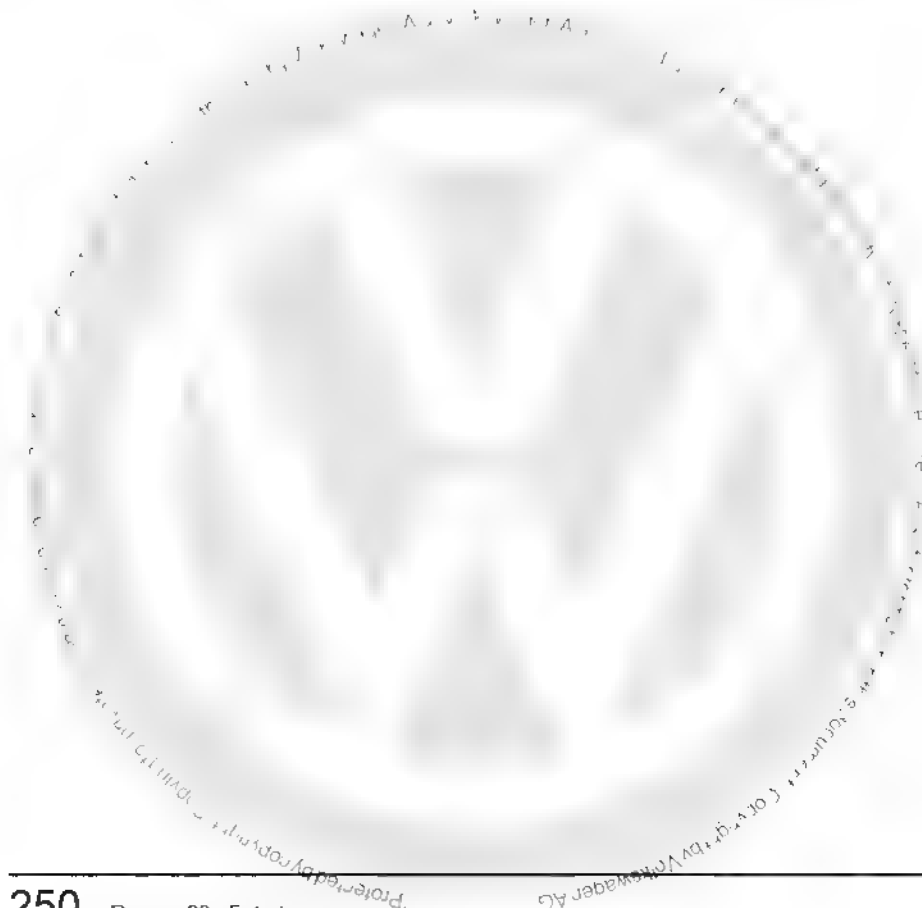
◆ Hot air blower - VAG 1416-

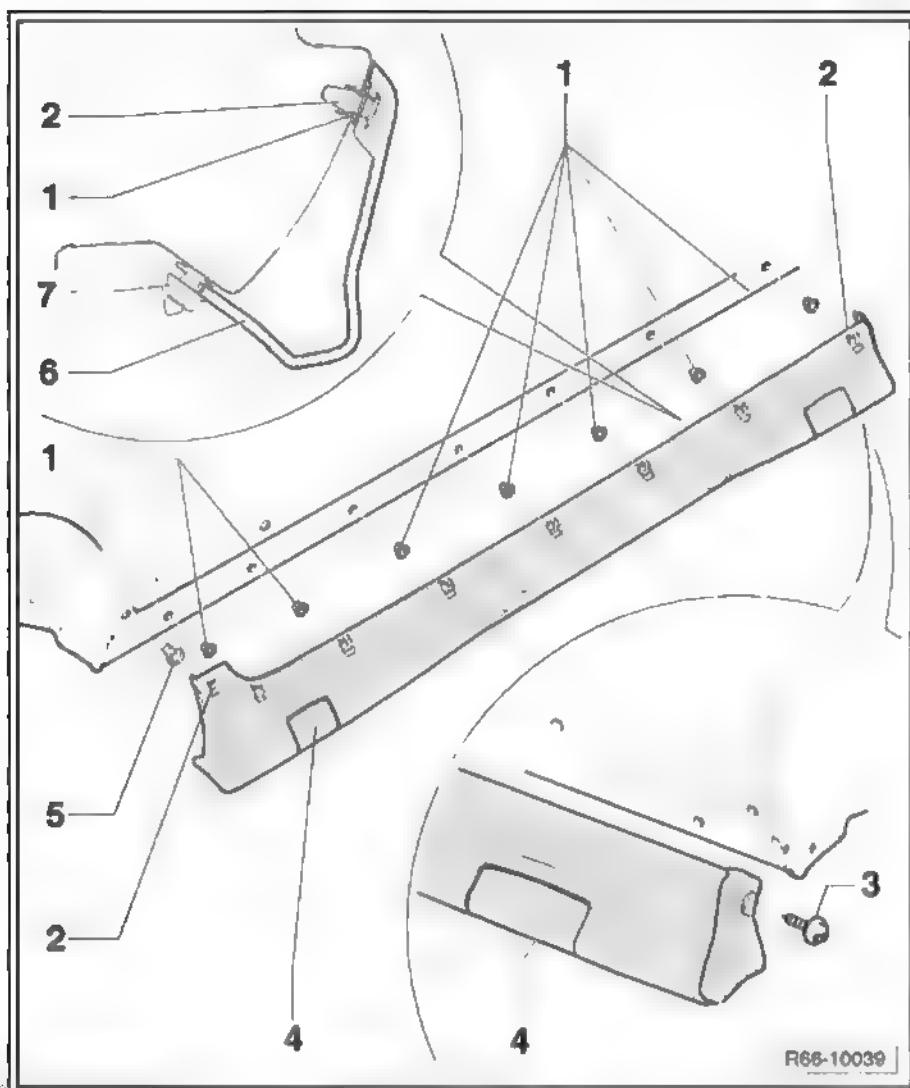


◆ Pressure roll - 3356-



7.3.1 Remove





- Remove screw -3- and nut -7-.
- Detach external longitudinal member lower lining -6- by heating it with a hot air blower - VAG 1416- .
- Remove lining by disengaging it from clamps -1-.

7.3.2 Install



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual, Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

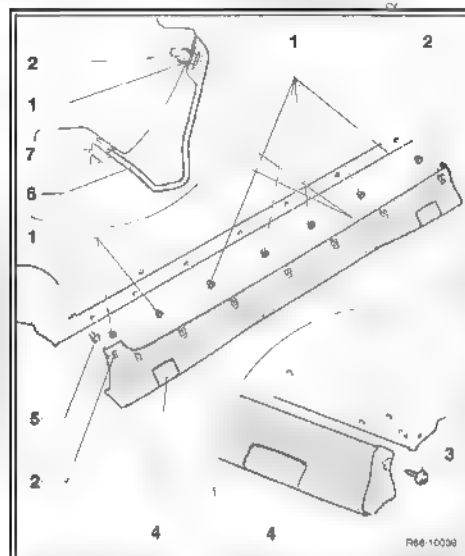


- Clean the body area where the footboard rear lining will be glued to the body with adhesive remover - D 002 000 10- and then apply the cleaning solution - D 009 401 04-.
- Heat up the side member's lower trim -6- in the area with the double-sided adhesive tape with the hot air blower - VAG 1416-
- Place the side member's lower trim and press it against the body. Install screw -3- and nuts -7-.
- Press external longitudinal member lower lining edges with double-sided adhesive tape against body with the pressure roll - 3356-



Note

Operating temperature approx. 20°C.





8 Wheel arch protector

8.1 Front wheel arch protector - remove and install

1 - Wheel arch protector

- ☐ remove
- Remove the wheel
Tightening torque for
the wheel screws ⇒
Chassis; Rep. gr. 44 ;
Wheels, tires, vehicle di-
mensions
- Remove screws -2- and
wheel arch protector.

2 - Bolt

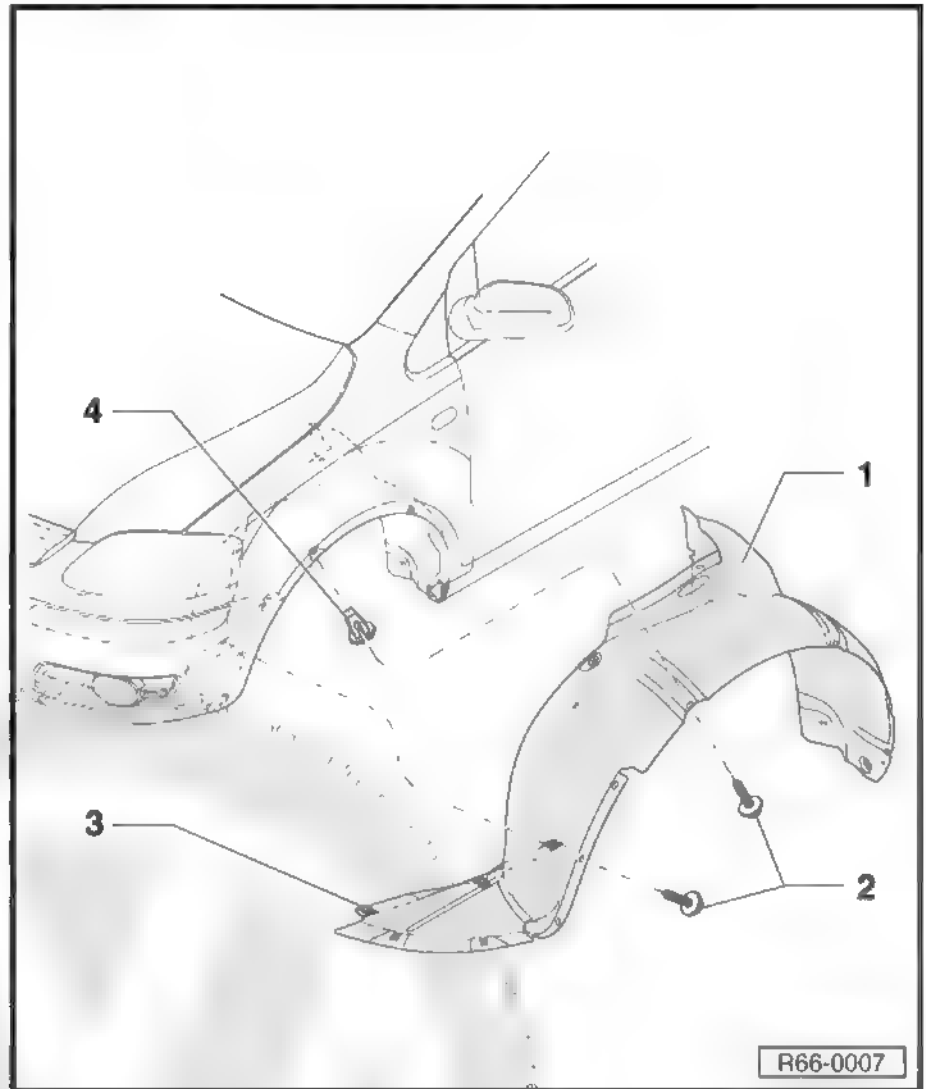
- ☐ 13 units
- ☐ Torque: 1.5 Nm

3 - Speed nut

- ☐ 3 units

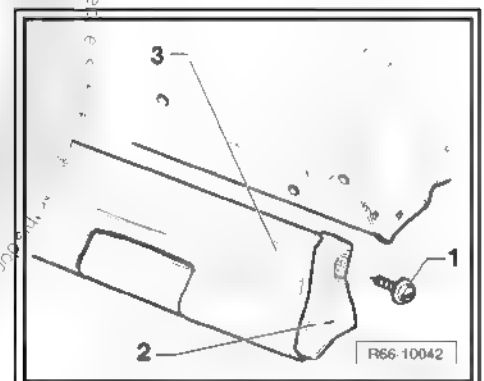
4 - Bushing

- ☐ 8 units
- ☐ replace if necessary



Note

For models with lower longitudinal member trim -3-, screw -1- must be removed and cover -2- must be disengaged in order to remove wheel case protector.





8.2 Rear wheel arch protector - remove and install

1 - Wheel arch protector

- ☐ remove
- Remove the wheel
Tightening torque for
the wheel screws ➤
Chassis, Rep. gr. 44 ;
Wheels, tires, vehicle di-
mensions
- Remove screws -3- and
wheel arch protector.

2 - Speed nut

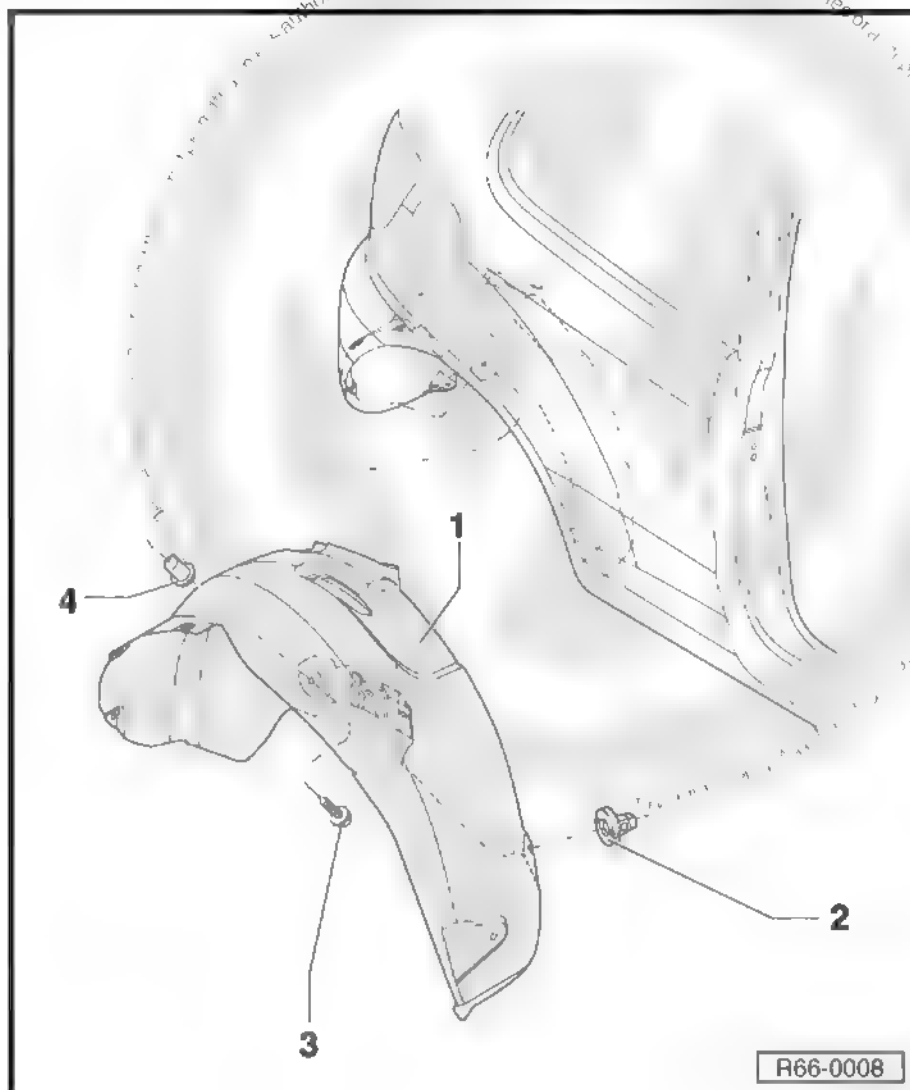
- ☐ 3 units

3 - Bolt

- ☐ 8 units
- ☐ Torque: 1.5 Nm

4 - Bushing

- ☐ 2 units
- ☐ replace if necessary





8.3 Rear wheel arch protector (Spacefox) - remove and install

1 - Rear wheel case protector

☐ remove:

- Remove the wheel.
Tightening torque for the wheel screws ⇒
Chassis; Rep. gr. 44 ;
Wheels, tires, vehicle dimensions
- Remove screws -3- and
wheel arch protector.

2 - Bushing

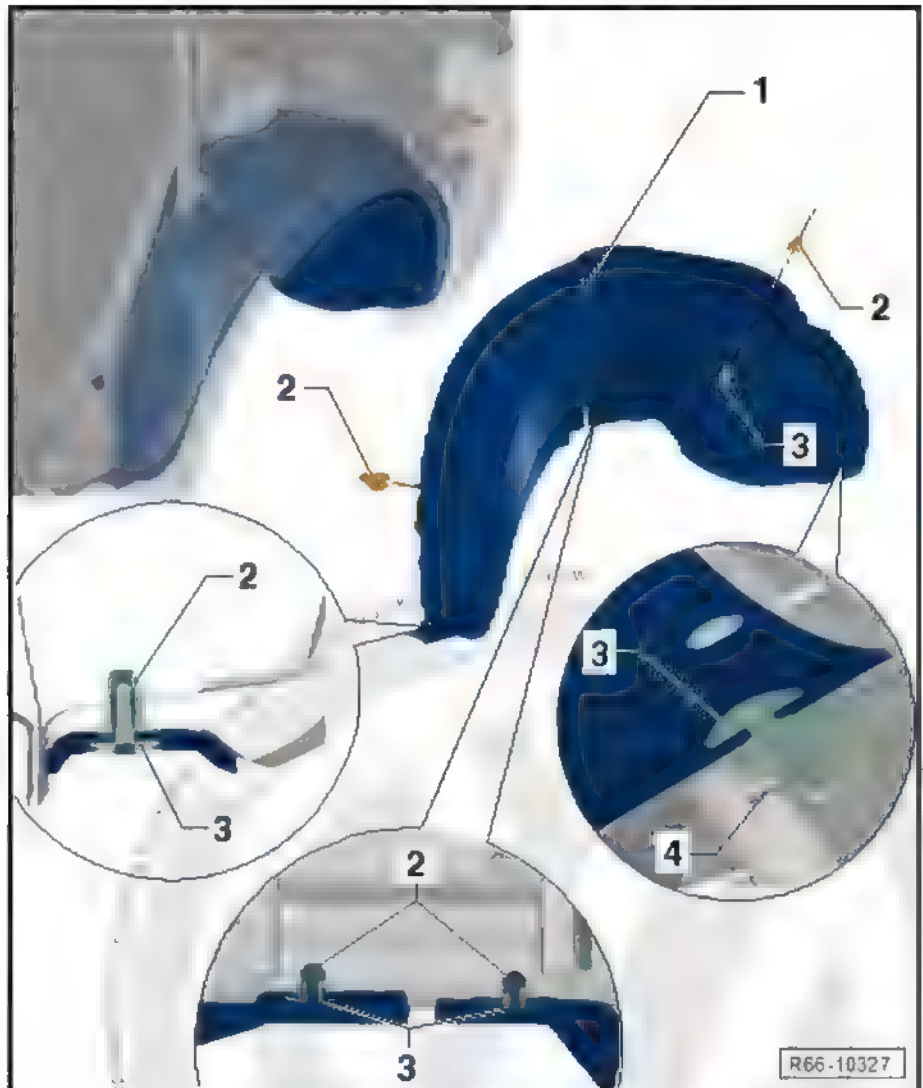
- ☐ 7 units
- ☐ replace if necessary

3 - Bolt

- ☐ 11 units
- ☐ Torque: 1.5 Nm

4 - Speed nut

- ☐ 4 units

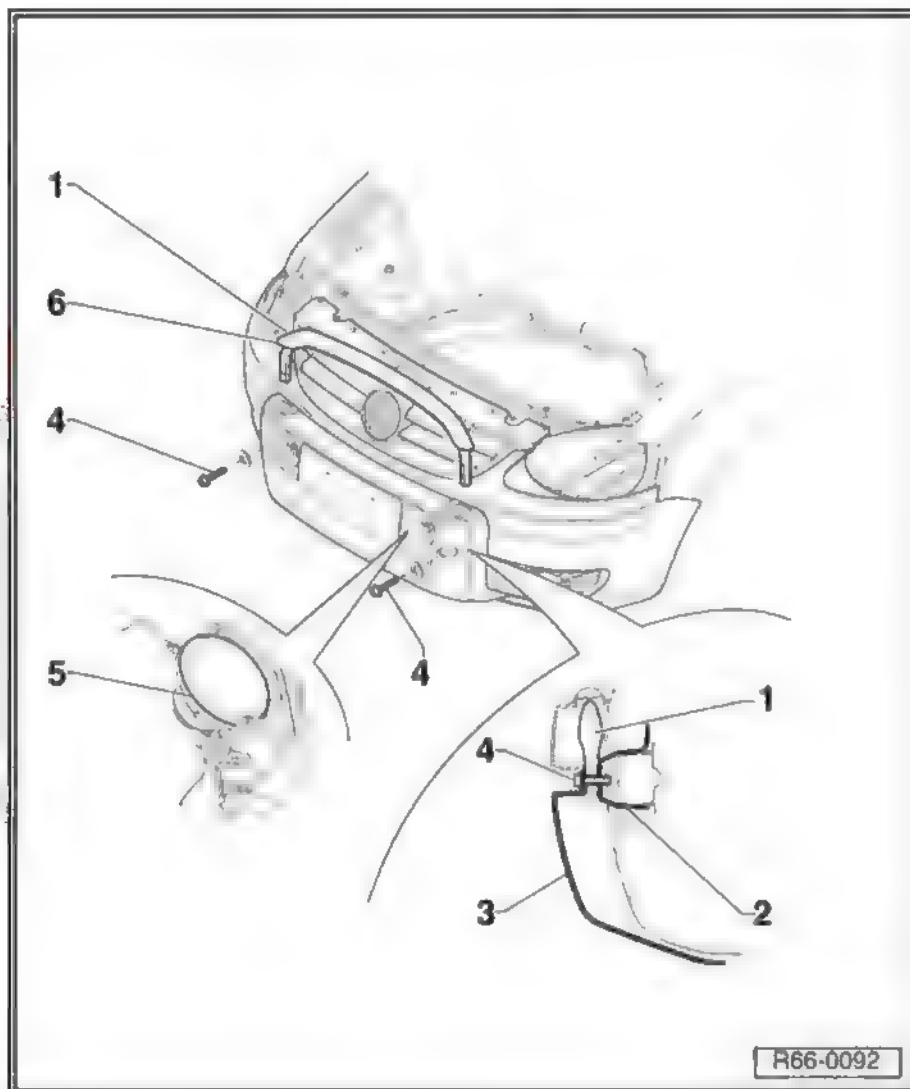




9 Central bumper protector - (Cross-Fox)

9.1 Front bumper centre protector (Crossfox ; ► 2007) - assembly overview

- 1 - Cross piece
- 2 - Lower cross member
- 3 - Central bumper protector
 - ❑ Remove and install
⇒ [page 256](#)
- 4 - Bolt
 - ❑ 2 units
 - ❑ Torque: 40 Nm
- 5 - Long-range headlights
- 6 - Finishing rubber



9.2 Front bumper centre protector (Cross-Fox ; ► 2007) - remove and install

Special tools and workshop equipment required



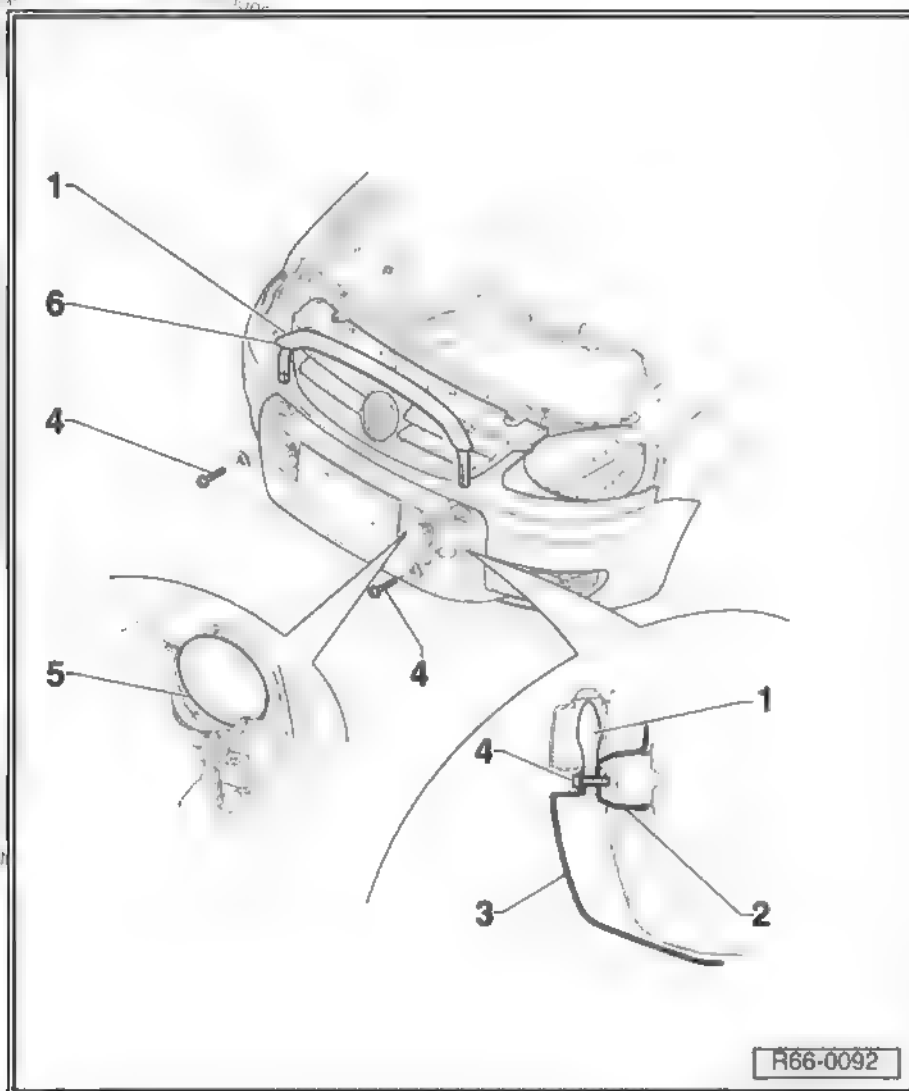
- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-

V.A.G 1331



W00 0427

Remove



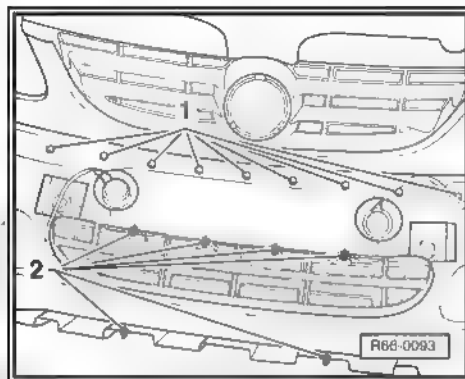
- Remove screws -4- (40 Nm).
- Remove cross member -1- and finishing rubber -6-
- Remove front bumper.



- Remove nuts -1- and screws -2-.
- Remove protector.
- Remove long-range headlights

Install

- Installation is performed in the reverse sequence to the removal.



9.3 Front bumper centre protector (CrossFox ; 2008 ➤) - remove and install

1 - Cover

- ☐ fitted to central protector.
- ☐ central protector removal is necessary in order to remove.

2 - Bolt

- ☐ 4 units

3 - Central protector

- ☐ Remove
 - Remove the front protector.
 - Remove screws -2- and nuts -6-.
 - Carefully disengage protector.
- ☐ Install
 - Installation is performed in the reverse sequence to the removal.

4 - Long-range headlights

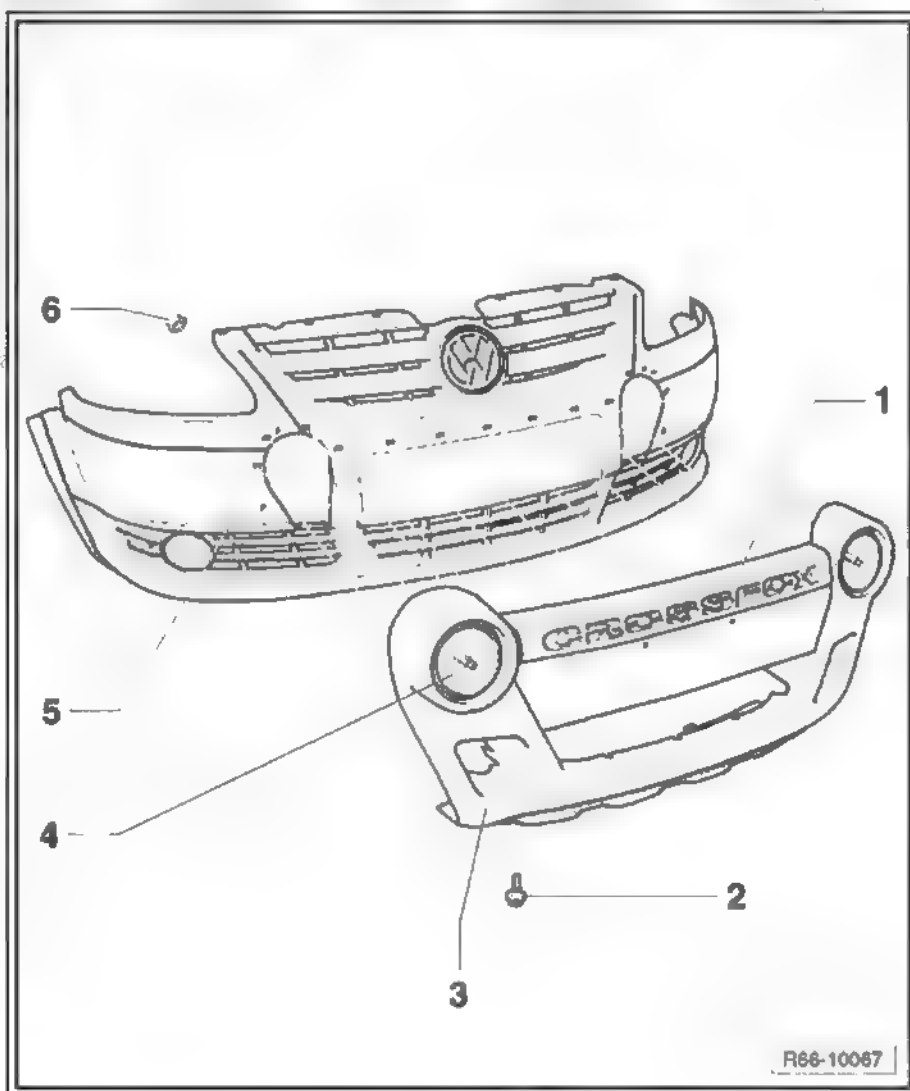
- ☐ ⇒ Electrical equipment; Rep. gr. 94 ; Switches, lights and external lights

5 - Front protector

- ☐ Remove and install

6 - Nut with integrated washer

- ☐ 15 units





9.4 Rear bumper central protector (CrossFox) - remove and install

1 - Spare wheel support passage frame

2 - Central bumper protector

☐ Remove

- Remove rear protector .

- Remove nuts -6- .

- Disengage and remove the protector

☐ Install

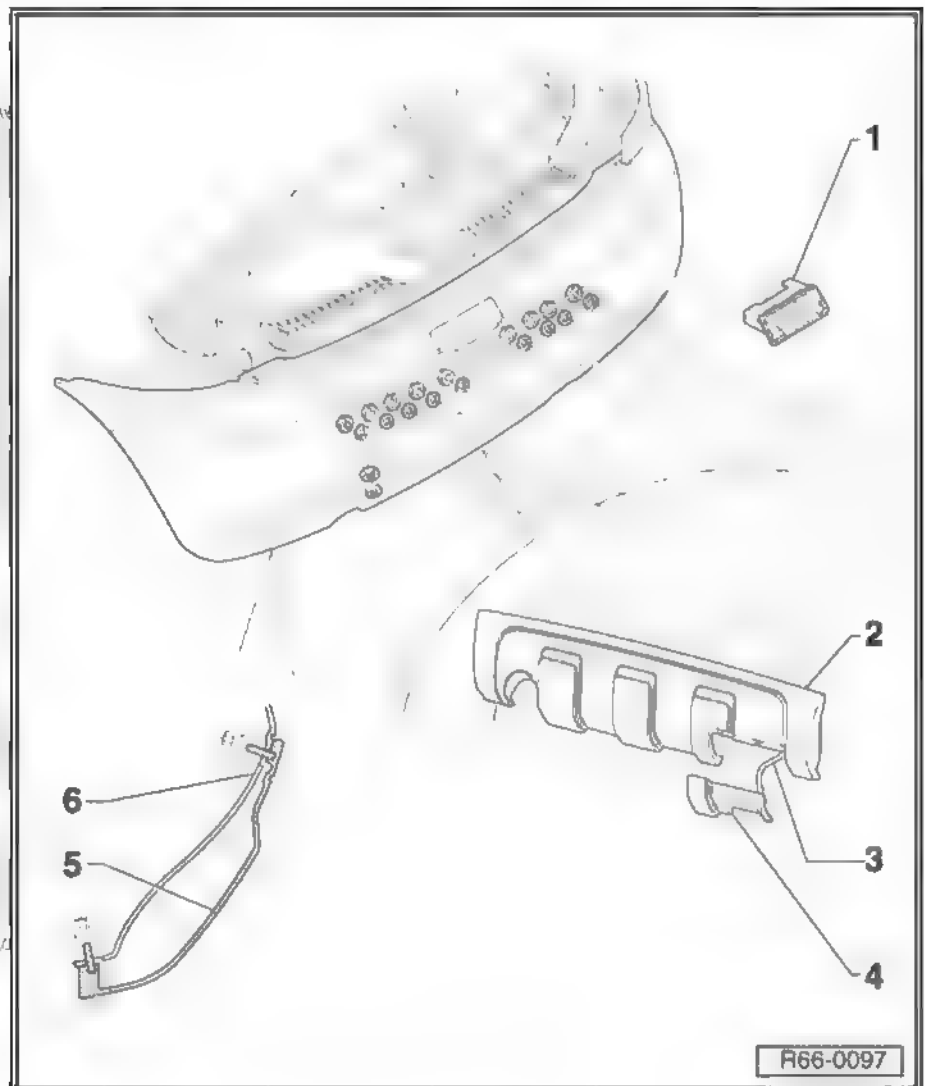
- Installation is performed in the reverse sequence to the removal.

3 - Cable

4 - Tow hook access finishing

5 - Washer

6 - Nut





10 External linings

10.1 Lower windscreen covering - assembly overview

1 - Lower windscreen covering

- ☐ Remove and install
⇒ [page 261](#)

2 - Additional seal

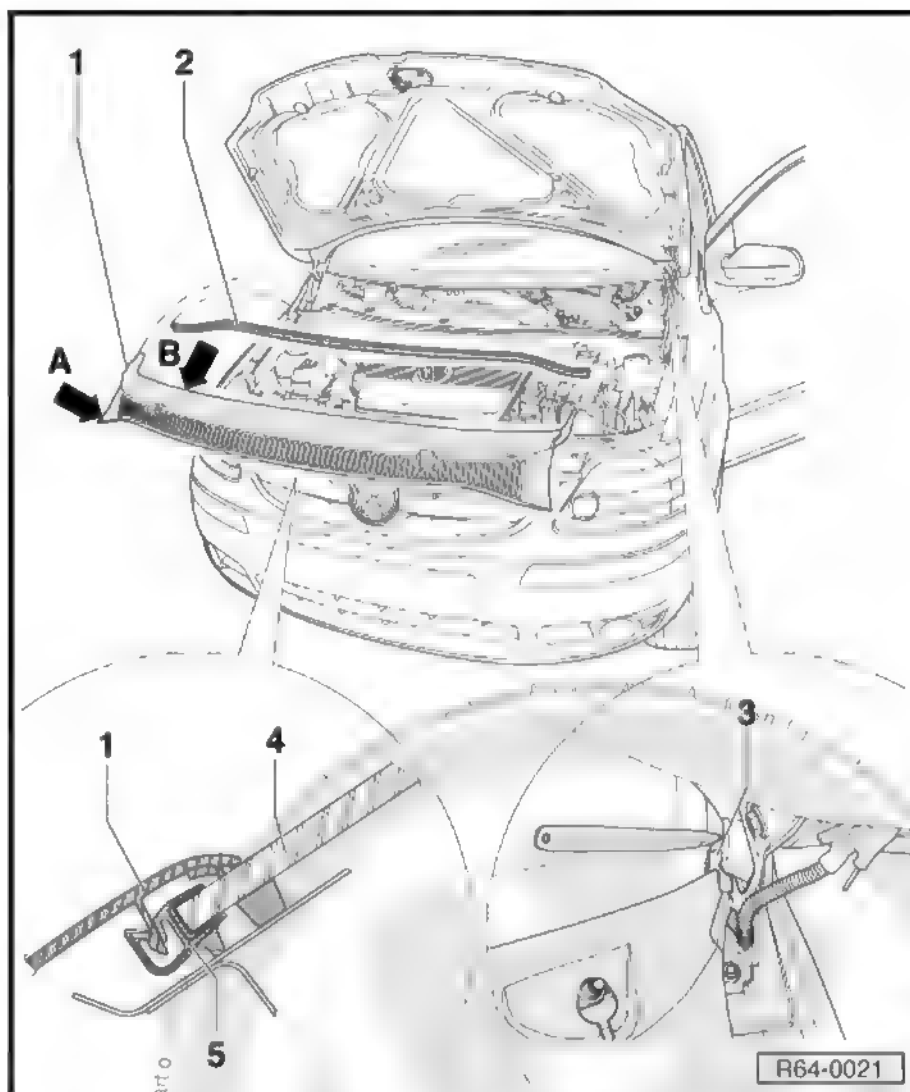
- ☐ fitted to water reservoir
flange

3 - Cap

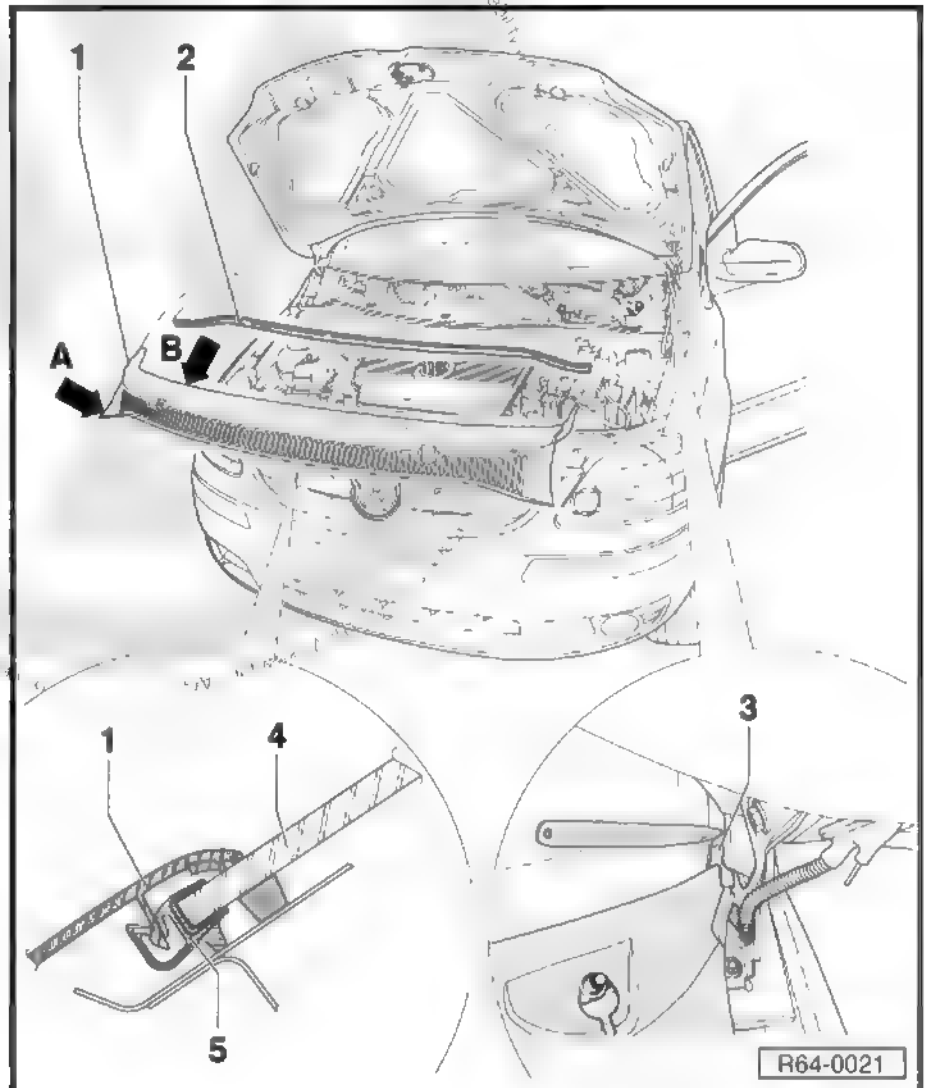
- ☐ on water case cover.

4 - Windscreen

5 - Fitting trim

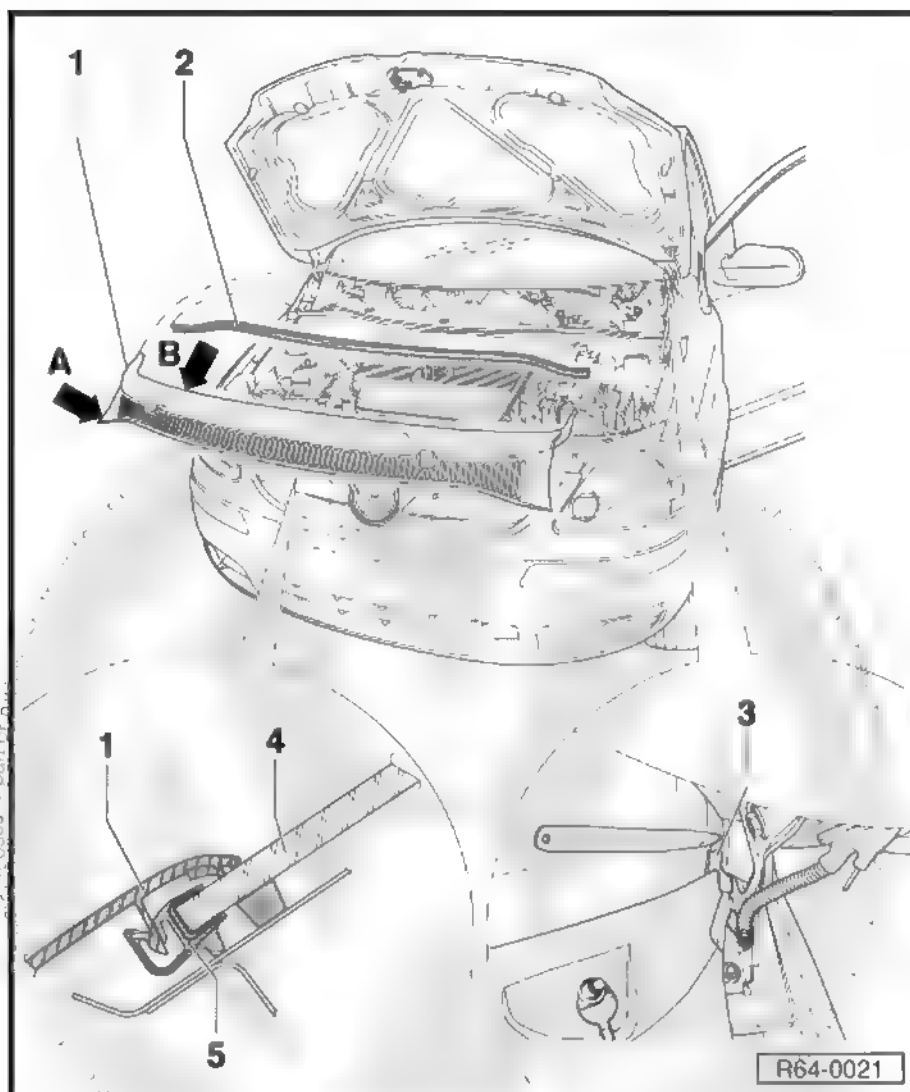


10.2 Lower windscreen covering - remove and install



Remove

- Remove the windscreen wiper arms ⇒ Electrical system; Rep. gr. 92 ; Windscreen wiper
- Remove the sealing trim -2- at full length.
- With a plastic wedge (for instance, that of -V.A.G 1755-), press windscreen lower lining -1- tabs -3- forward from left and right between hinge and front lid
- Carefully pull windscreen lower lining upward -1- from right -arrow A- out of fitting trim -5- on the windscreen -4-.



Install

- To better fasten the lower windscreen lining -1- to the fitting trim -5-, apply a neutral soap solution.
- Place windscreen lower lining -1- on the windscreen -4- fitting trim -5- and, starting from center section -arrow B-, fit the windscreen lower lining to support -5- by slightly pressing it.
- With a plastic wedge (for instance, that of -V.A.G 1755-), place windscreen lower lining -1- covers -3- on installation position at left and right between hinge and front lid.
- Press sealing packing over lower lining -2-.
- Install the windscreen wiper arms ⇒ Electrical system; Rep. gr. 92 , Windscreen wiper .



10.3 Floor lower lining - assembly overview

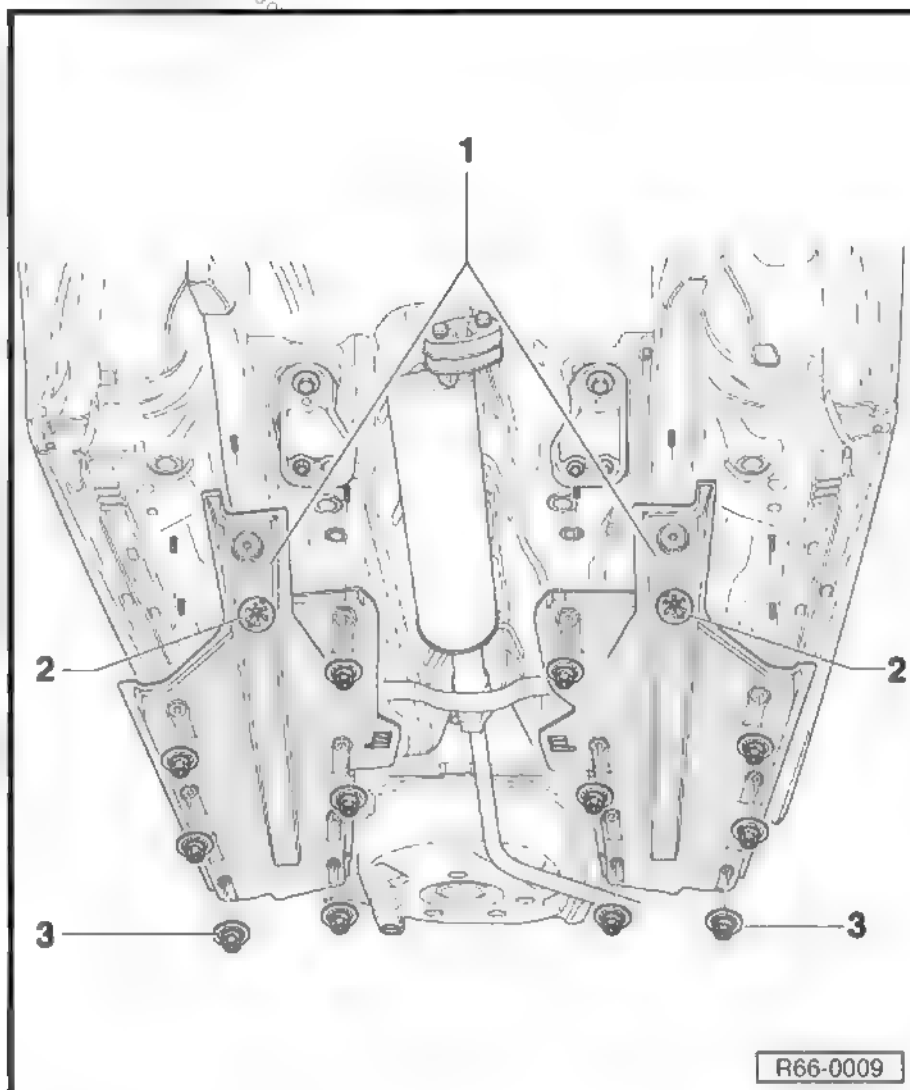
1 - Lining

2 - Push on lock washer

- ☐ Torque: 1.5 Nm
- ☐ fastened to body threaded pin
- ☐ on assembly it must be fastened, not pressed

3 - Plastic nut

- ☐ Torque: 1.5 Nm
- ☐ fastened to lining through tabs
- ☐ fastened to body threaded pin



R66-0009

10.4 Lower longitudinal member external lining - replace



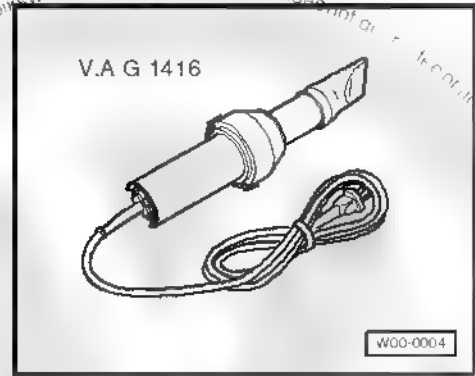
Note

For versions: Space Cross, Fox Rock in Rio etc., the following procedures are valid.

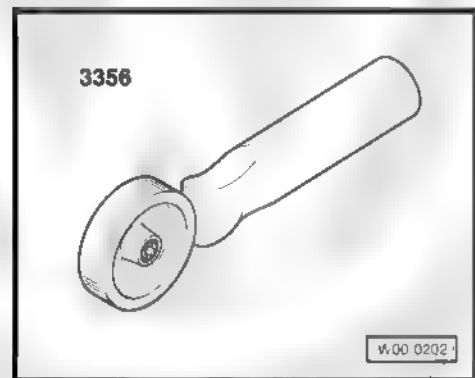
Special tools and workshop equipment required



◆ Hot air blower - VAG 1416-



◆ Pressure roll - 3356-



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Lower longitudinal member external lining (Crossfox)

- ☐ self-adhesive
- ☐ Glued under the external lining of the lower member
- ☐ Clean the external lining of the lower member with cleaning solution - D 009 401 04- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.

a = 16.5 mm

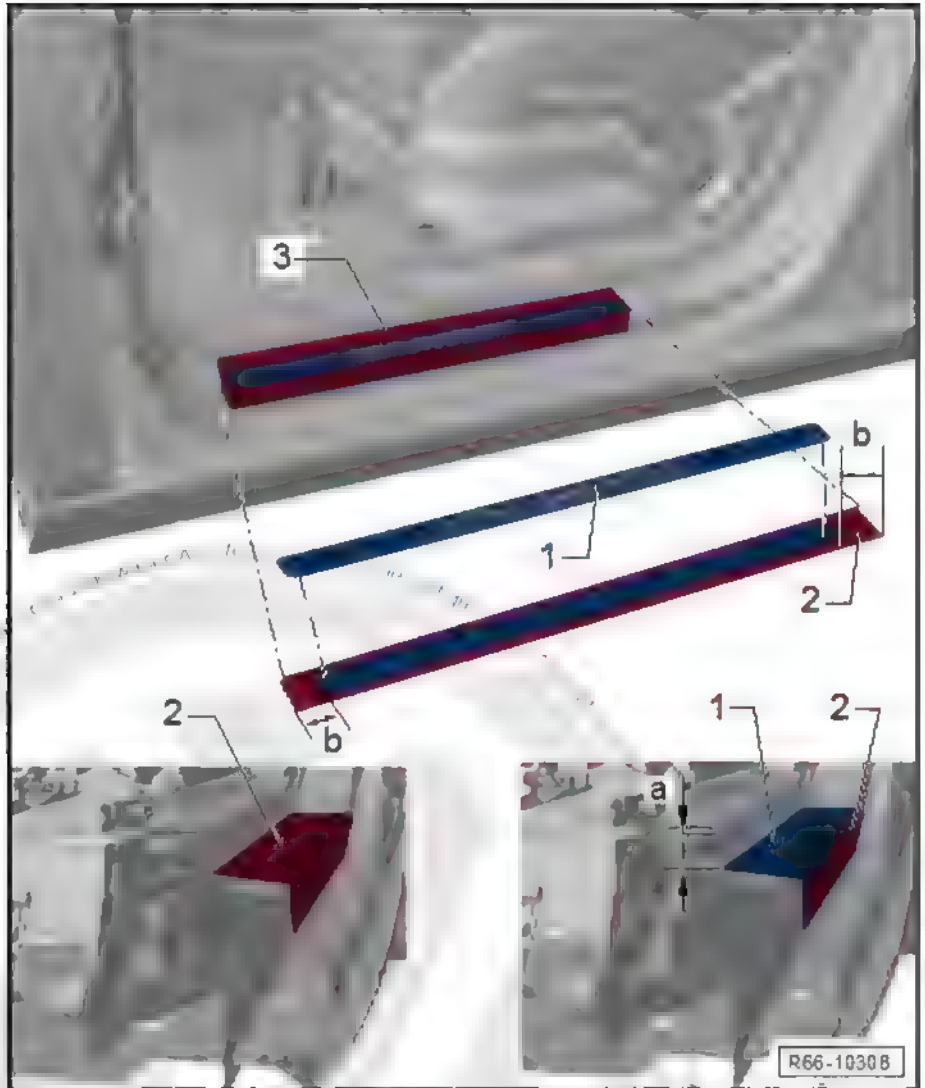
b = 15 mm

2 - Lower longitudinal member external lining

- ☐ self-adhesive
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416-
- ☐ Remove the adhesive tape liner, place the lining (aligned with the curve on side panel -arrow-) and press it strongly pressure roll - 3356- . Operating temperature approx. 20°C.

3 - Front door external lining assembly area

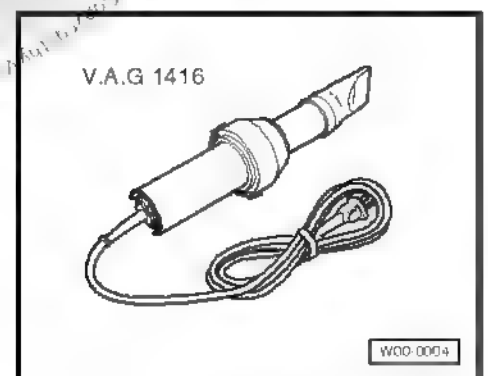
- ☐ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .



10.5 Pillar and door external lining - replace

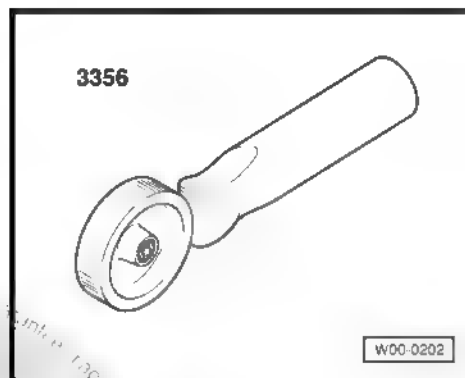
Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416





◆ Pressure roll - 3356-



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

1 - Front door external lining assembly area

- ❑ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

2 - Rear door external lining assembly area (rear section)

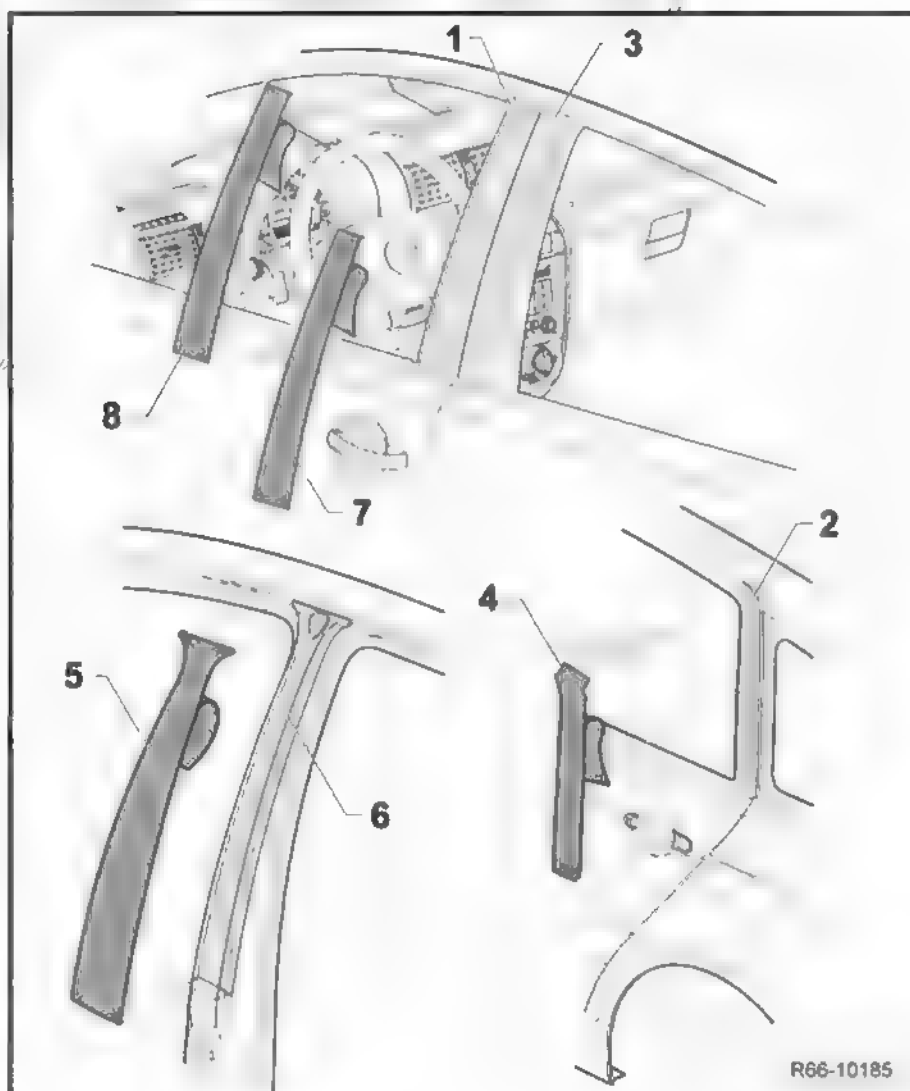
- ❑ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

3 - Rear door external lining assembly area (front section)

- ❑ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

4 - Rear door external lining (rear section)

- ❑ self-adhesive
- ❑ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ❑ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.





5 - Pillar B external lining assembly area

- ☐ Clean the area using adhesive remover - D 002 000 10- , then apply the cleaning solution - D 009 401 04- .

6 - Central pillar external lining

- ☐ self-adhesive
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.

7 - Rear door external lining

- ☐ self-adhesive
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.

8 - Front door external lining

- ☐ self-adhesive
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.





11 Rear and front spoiler (Fox)

11.1 Front spoiler (Fox 09.06 ►) - remove and install

1 - Nut with washer

2 - Bolt

3 - Front spoiler

☐ remove

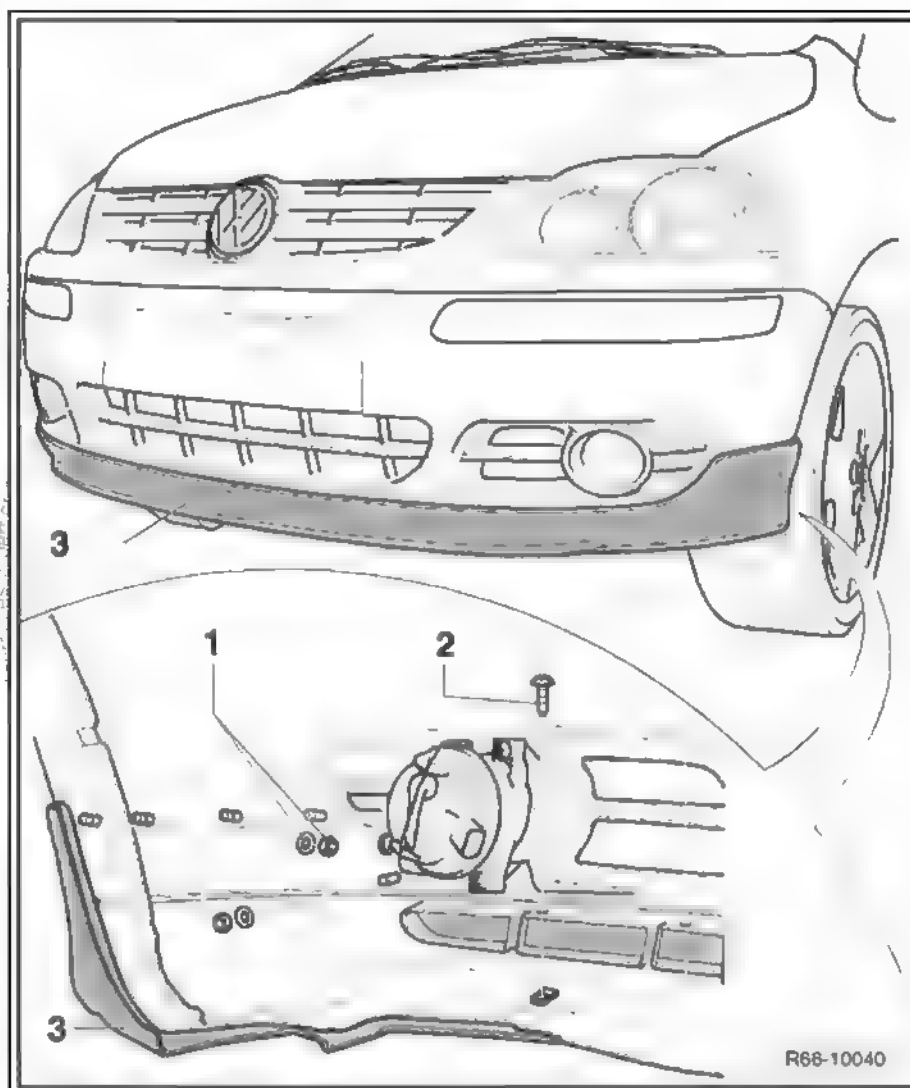
- Remove front protector of bumper .

- Remove nuts + washers -1- and screws -2-.

- Disengage and remove the spoiler.

☐ install

- Installation is performed in the reverse sequence to the removal.





11.2 Rear spoiler (Fox 09.06 ►) - remove and install

1 - Tow hook cover

2 - Nut with washer

3 - Rear spoiler

☐ remove

- Remove rear bumper protector .

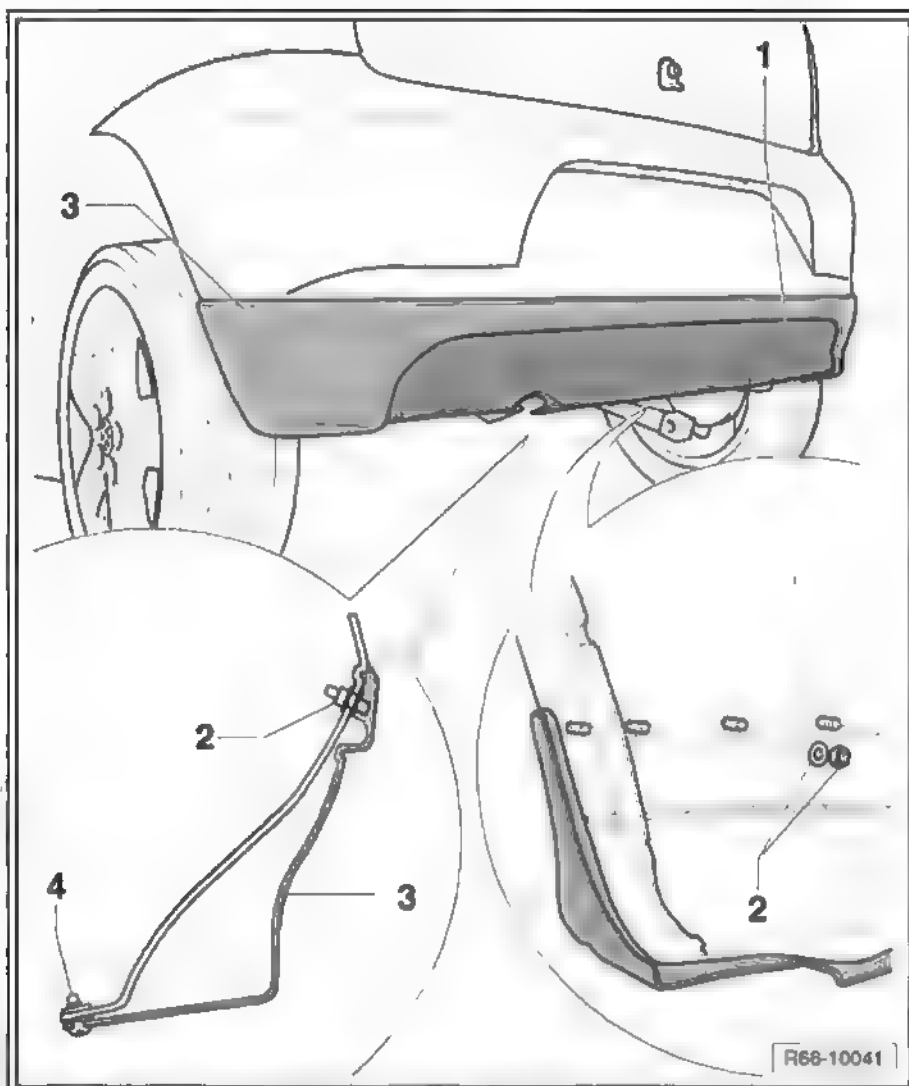
- Remove nuts + washers -1- and screw -2-.

- Disengage and remove the spoiler.

☐ install

- Installation is performed in the reverse sequence to the removal.

4 - Bolt



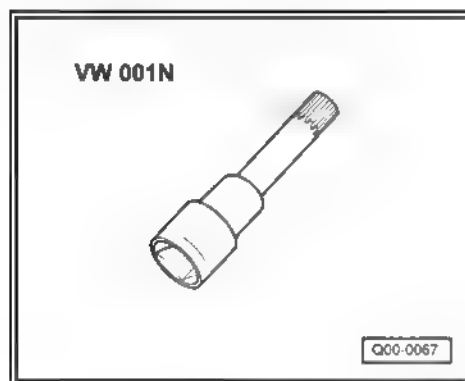


12 Spare wheel support (CrossFox)

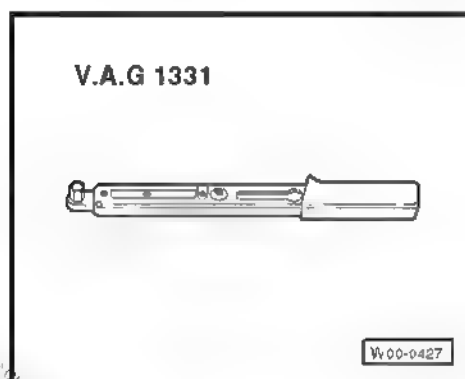
12.1 Spare wheel support upper (fixed) hinge - remove and install

Special tools and workshop equipment required

- ◆ Multi-teeth socket - M11/M12 (1/2" drive) - VW 001N ou 3452 ou Gedore - INX19L-12-



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Bolt

- ☐ Torque: 25 Nm
- ☐ upper hinge fastening

2 - Bolt

- ☐ Remove it with multi-tooth socket - M11 / M12 (fit. 1/2") - VW 001N ou 3452 ou Gedore - INX19L-12-
- ☐ Torque: 30 Nm

3 - Plug

4 - Upper hinge

- ☐ Remove
 - Remove spare wheel support.
 - Remove plugs -3- and screws -2-.
- ☐ Install
 - Replace hinge sealing.



Note

Sealing deforms permanently and cannot prevent water from the vehicle. Because of this, it must be replaced.

- Installation is performed in the reverse sequence to the removal.

5 - Sealing

- ☐ PVC foam, self-adhesive - 5Z6 802 791-
- ☐ "5-mm" thickness
- ☐ before removal, heat sealing with the hot air blower - VAG 1416- .
- ☐ when installing sealing, clean adhesion area on hinge with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04-

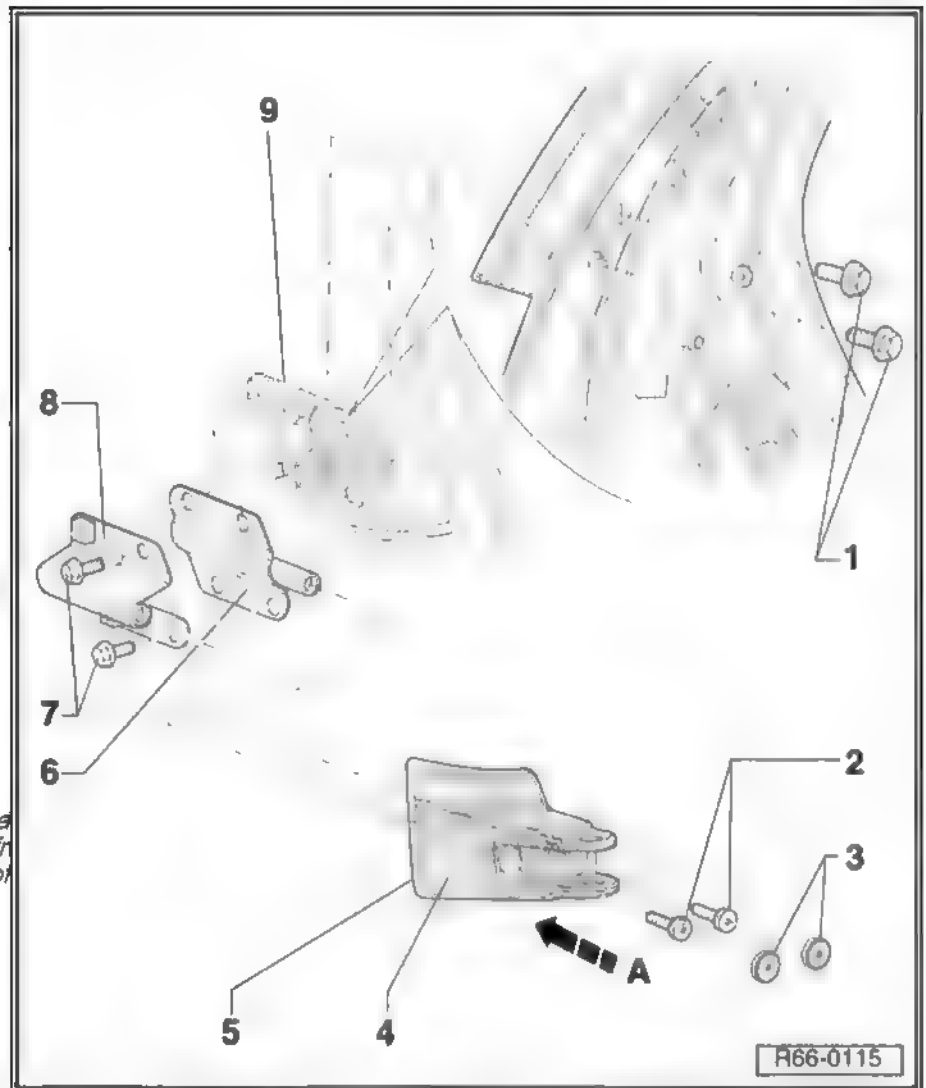
6 - Internal support

7 - Bolt

- ☐ Torque: 25 Nm

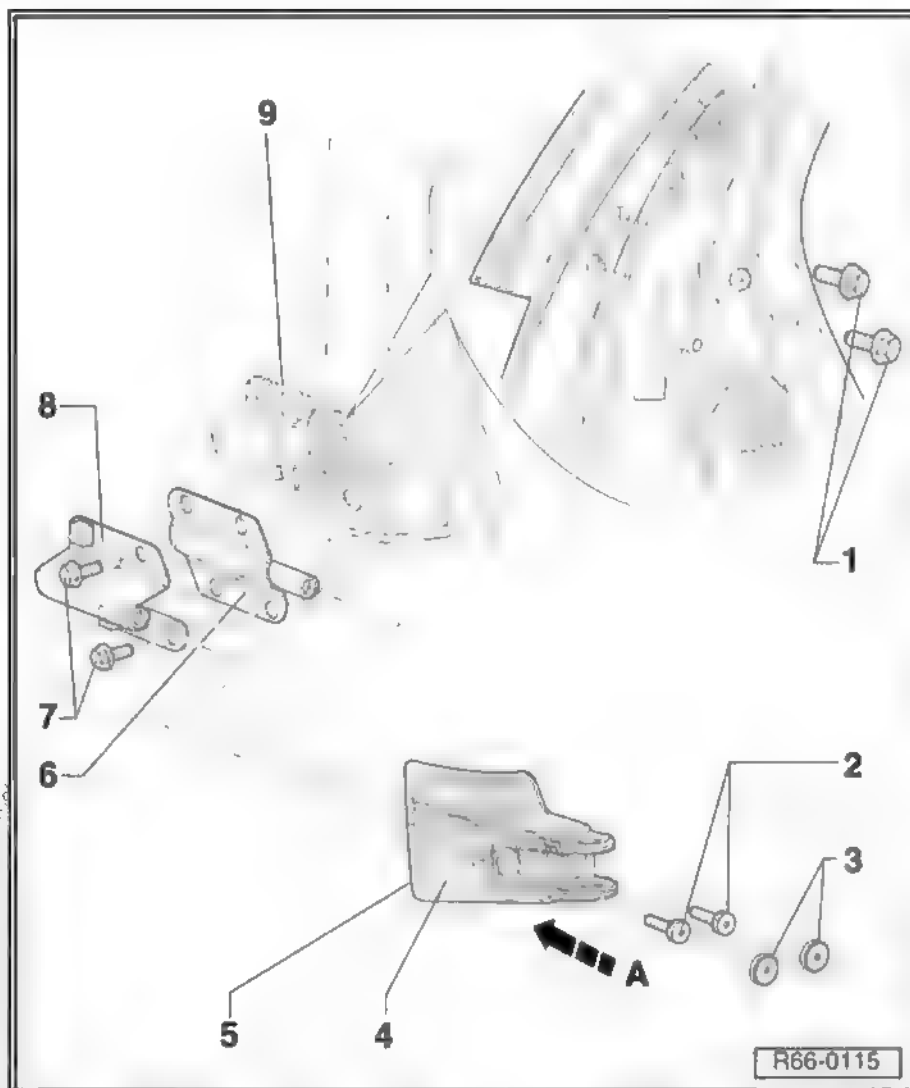
8 - External support

9 - Internal panel





12.2 Spare wheel support upper (fixed) hinge - position adjustment



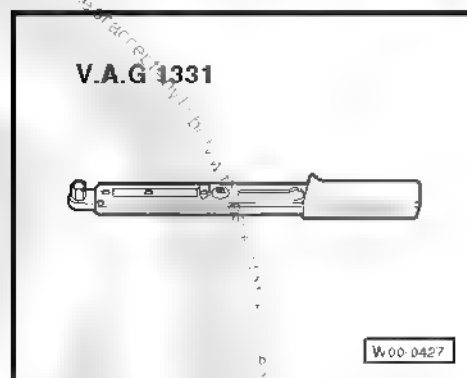
- Remove hinge.
- Release the screws -1- and -7-.
- Temporarily install hinge. Place hinge towards -arrow A- so that it perfectly aligns with the external side panel.
- Tighten the screws -1-.
- Remove hinge.
- Tighten the screws -7-.
- Install hinge

12.3 Spare wheel support lower (fixed) hinge - remove and install

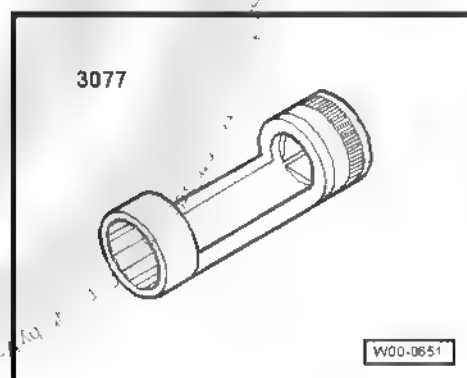
Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



- ◆ 19-mm socket - 3077-



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Bolt

- ☐ Torque: 2 Nm
- ☐ ➤ 2007 only

2 - Spare wheel support unlocking button

- ☐ ➤ 2007 only

3 - Button return spring

- ☐ ➤ 2007 only

4 - Unlocking button movement limiter

- ☐ ➤ 2007 only

5 - Bolt

- ☐ Torque: 20 Nm
- ☐ Remove and install
⇒ [page 276](#)
- ☐ upon installation, apply medium torque lock adhesive ⇒ Chemicals Manual

6 - Nut

- ☐ Torque: 30 Nm

7 - Plug

8 - Lower hinge

- ☐ Remove
 - Remove spare wheel support.
 - Remove plugs -7- and nuts -6-.

☐ Install

- Replace hinge sealing.

- Installation is performed in the reverse sequence to the removal.

9 - Sealing

- ☐ PVC foam, self-adhesive -5Z6 802 792-
- ☐ 5-mm thickness
- ☐ before removal, heat sealing with the hot air blower - VAG 1416- .
- ☐ when installing sealing, clean adhesion area on hinge with adhesive remover - D 002 000 10- and then apply cleaning solution - D 009 401 04- .

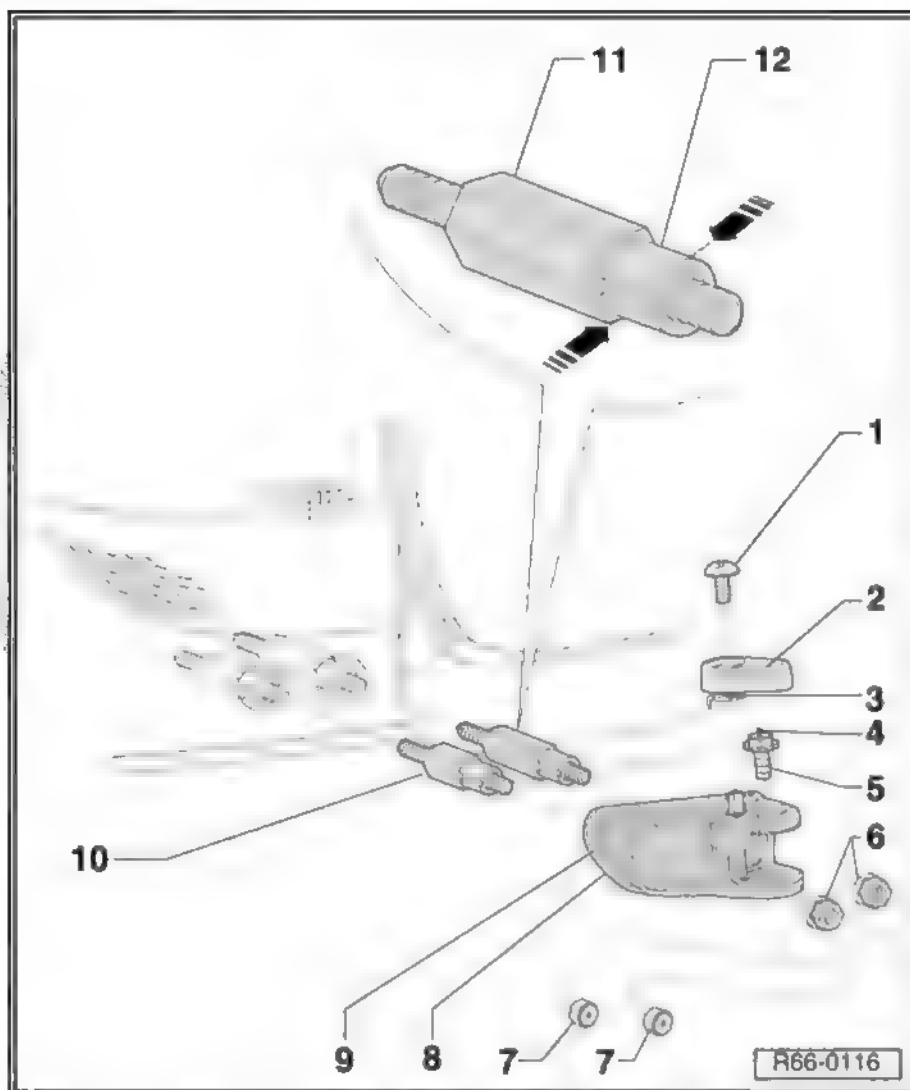
10 - Extender

- ☐ Torque: 40 Nm
- ☐ tighten extender with 19-mm socket - 3077-
- ☐ lower hinge fastening

11 - Extender body (hexagonal)

12 - Adjusting nut

- ☐ fastened by anaerobic adhesive.





12.4 Spare wheel support lower (fixed) hinge - position adjustment

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

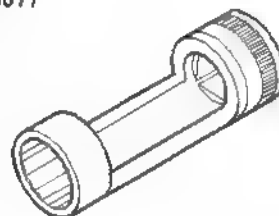
V.A.G 1331



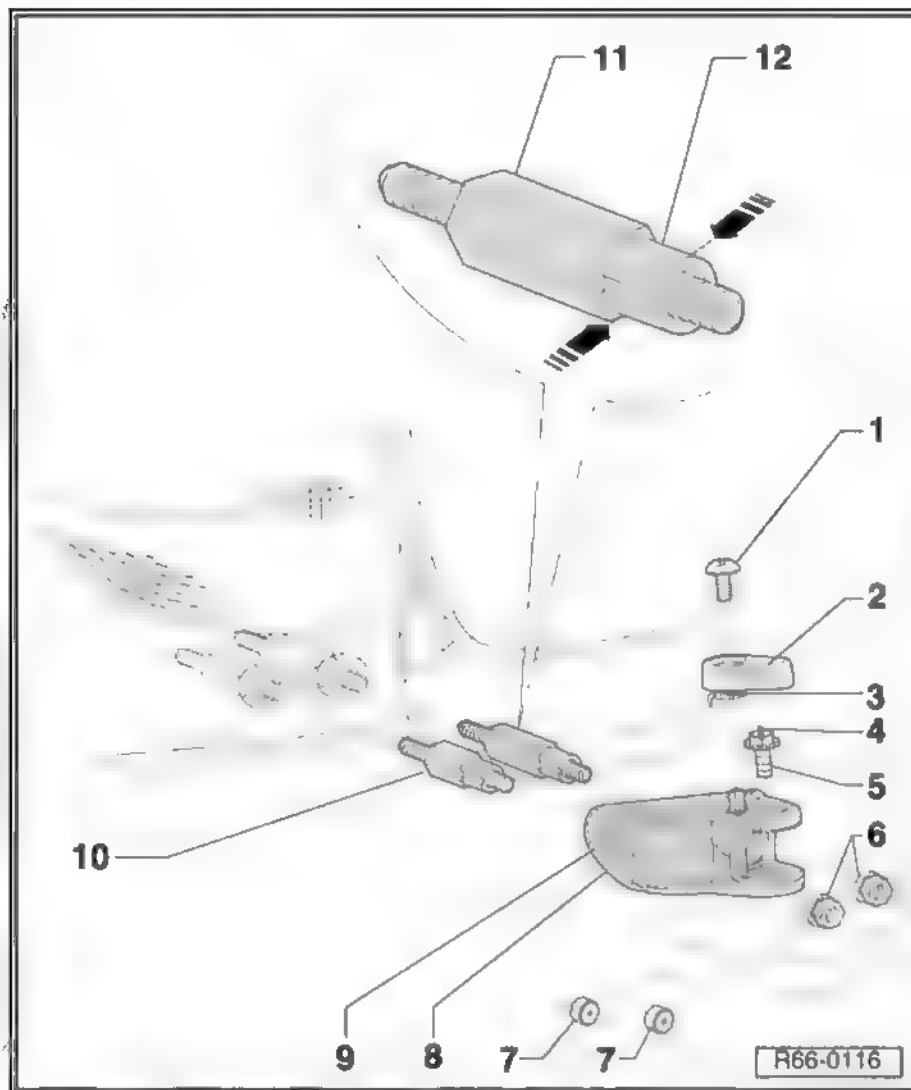
W00-0427

- ◆ 19-mm socket - 3077-

3077



W00-0651



- Remove hinge.
- Remove extenders.
- Fasten adjusting nut -arrows- to a vise and tighten or loosen extender body.



Note

Hinge will move away from external side panel by turning extender body to left; and it shall move closer if extender body is turned to right. Note that there must be a clearance between hinge and side panel.

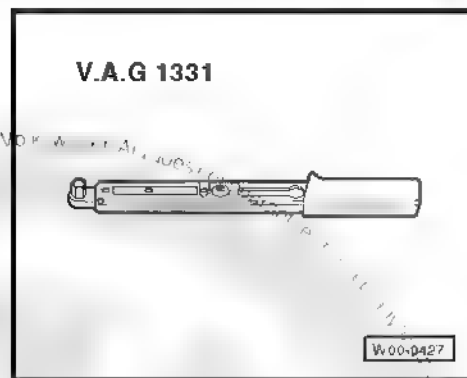
- Install the extenders with the 19-mm socket - 3077- .
- Install hinge

12.5 Hinge fastening screws for upper/lower hinges of the external spare wheel cover - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



12.5.1 Remove

- Remove spare wheel.



Note

The screws were assembled with medium torque lock adhesive, therefore, follow the procedure in order to release them.

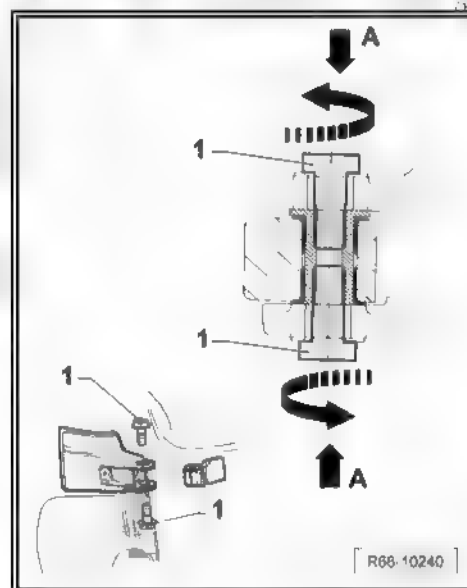
- Slightly tap screws -1-, in the direction of the -arrows A-, with a hammer.



Note

Do not hit screws directly on the head. Use a piece of metal to receive the direct impact in the direction of the arrows A.

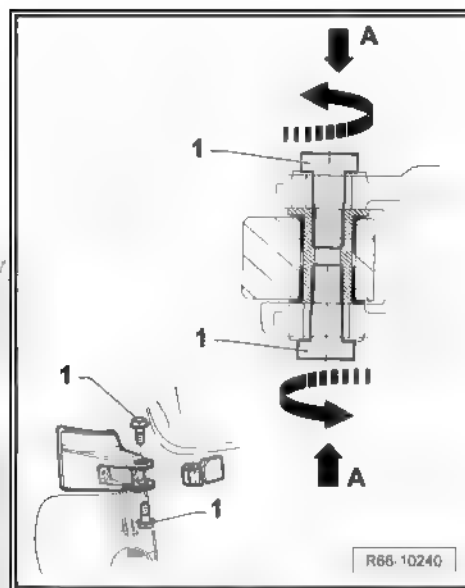
- With two keys (SW 18) to release the screws -1- simultaneously. If one of the screws breaks the adhesive between the threads of the screw and the bung, re-tighten it.
- Use a hammer to lightly tap the screw -1- that did not release.
- Release the screw -1- that did not release.
- Remove the bolts -1-.





12.5.2 Install

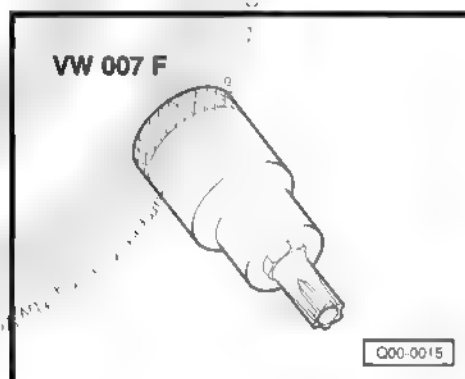
- Clean the threads of the screws and the bung.
- Apply the medium torque lock adhesive ⇒ See Chemicals Manual - List of authorized products - Medium torque lock adhesive on the screw threads -1-.
- Remove the screws -1- (20 Nm)



12.6 Spare wheel support (► 2007) - remove and install

Special tools and workshop equipment required

- ◆ Multi-tooth socket - M10 (fit. 1/2") - VW007F-



WARNING

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- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Pin

2 - Bolt

- ☐ Use multi-tooth socket - M10 (fit. 1/2") - VW007F- to remove it.
- ☐ Torque: 12 Nm

3 - Bolt

4 - Mounting bracket

- ☐ adjustable through screws -3-.

5 - Rubber striker

- ☐ Lubricate buffer on pin support -1- with silicone-based grease - G 000 405 A2-

6 - Mounting bracket

- ☐ Remove
- With the help of an assistant, remove screws -13-.
- Disengage support and remove it.
- ☐ Install
- Installation is performed in the reverse sequence to the removal.
- Adjust support position if necessary through hinges (mobile)

7 - Sliding

8 - Bolt

9 - Latch

10 - Bolt

11 - Hinge (mobile)

- ☐ Adjustable in position through screws -12-.

12 - Bolt

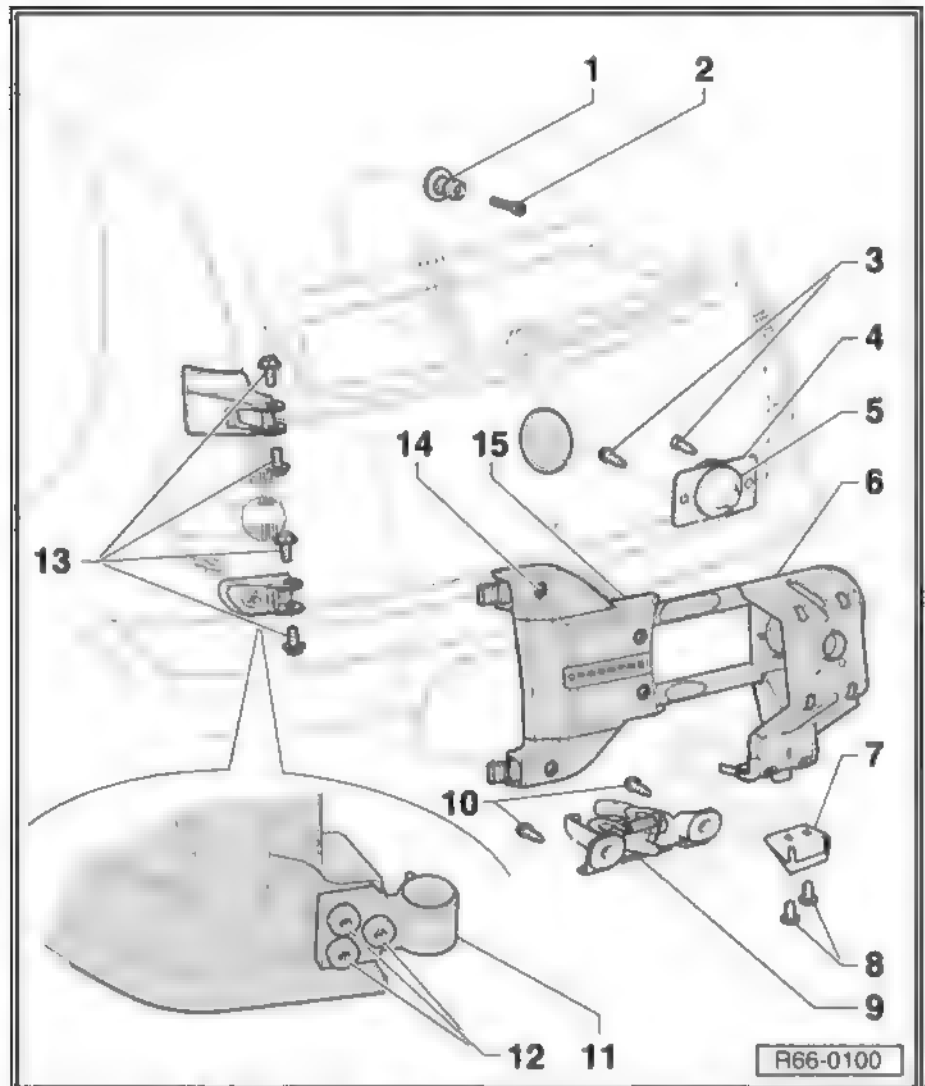
- ☐ Torque: 15 Nm

13 - Bolt

- ☐ Torque: 20 Nm
- ☐ Remove and install ⇒ [page 276](#)
- ☐ upon installation, apply **medium** torque lock adhesive ⇒ Chemicals Manual

14 - Bolt

15 - Cover

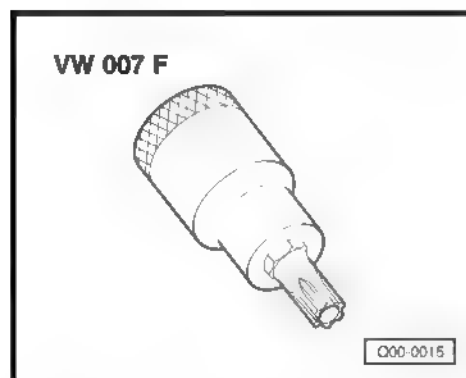


12.7 Spare wheel support (2008 ►) - remove and install

Special tools and workshop equipment required

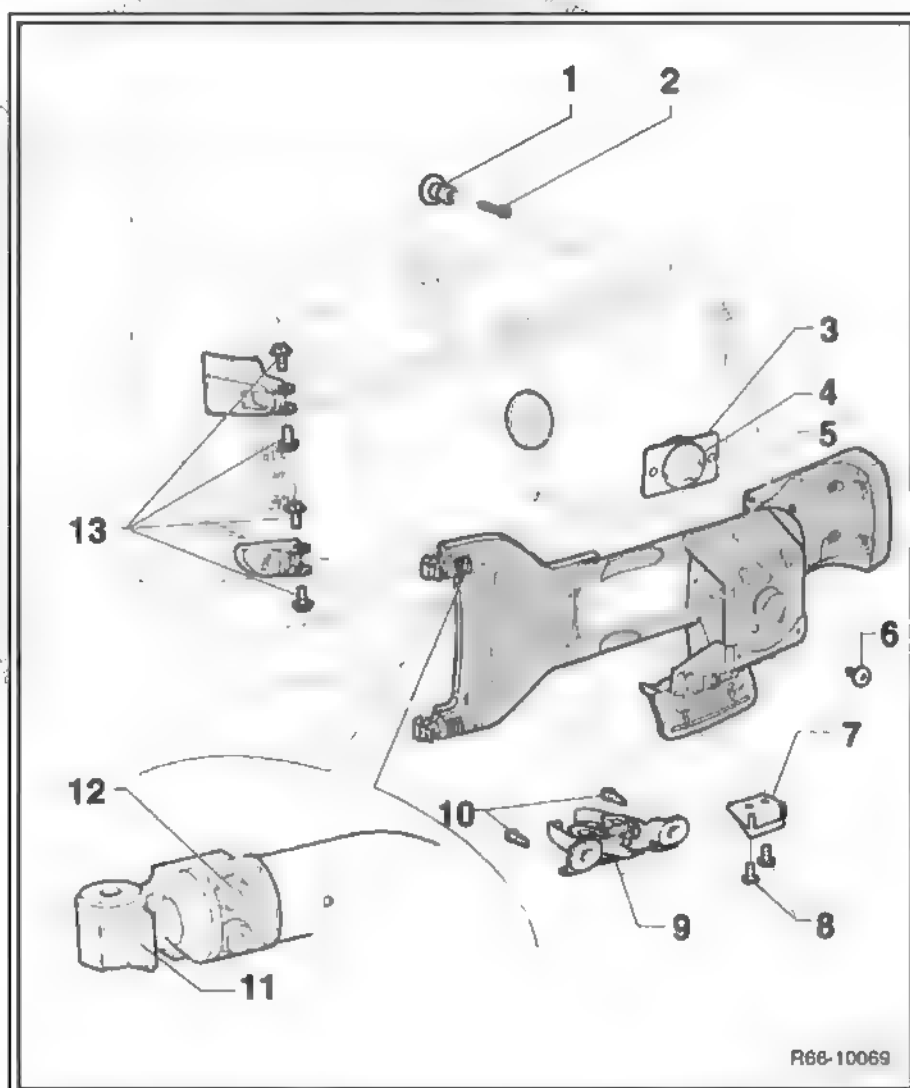


- ◆ Multi-tooth socket - M10 (1/2" drive) - VW007F-



12.7.1 Remove

- Remove spare wheel.
- Remove spare wheel support external cover.
- Remove support lock activation cable.

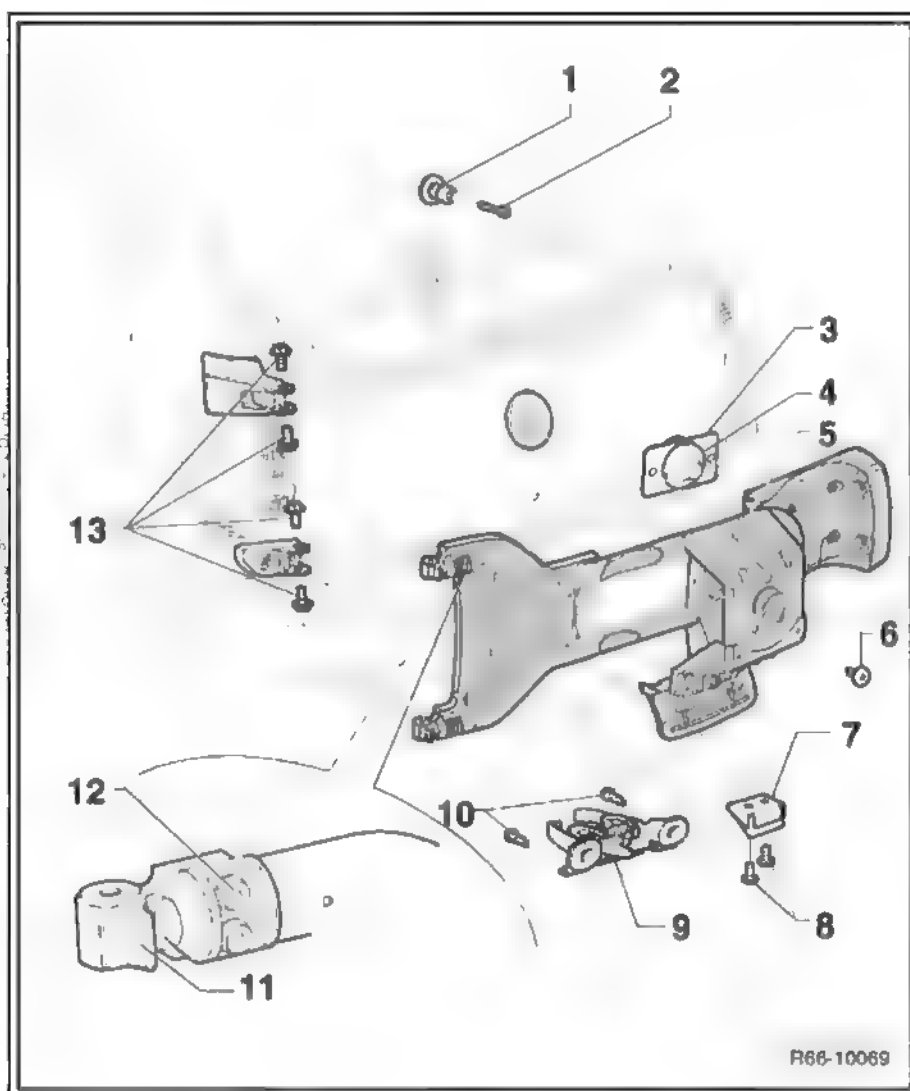


- With the help of an assistant, remove screws -12-
- Disengage support and remove it



12.7.2 Install

- Installation is performed in the reverse sequence to the removal



- Adjust support position if necessary through screws -12-.



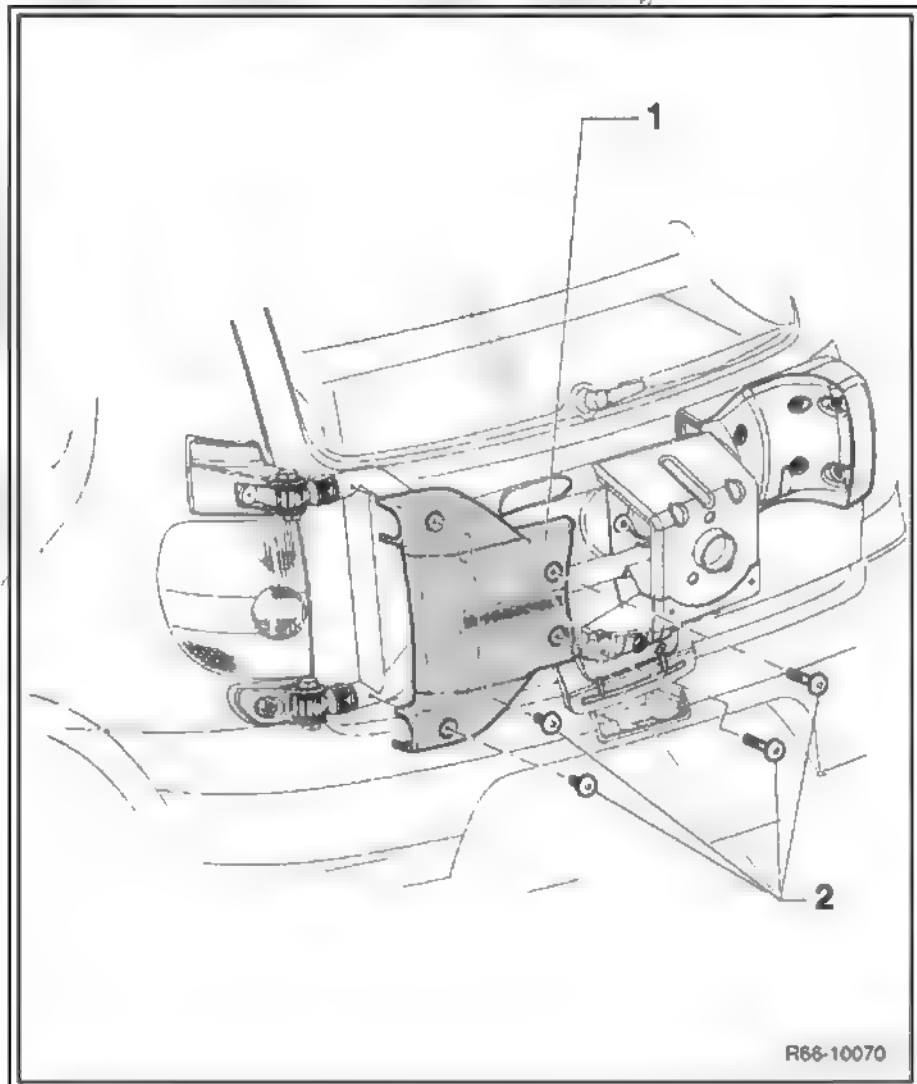
12.8 Spare wheel support external cover (2008 ►) - remove and install

1 - Cover

- ☐ Remove
 - Remove spare wheel.
 - Remove the bolts -2-.
- ☐ Install
 - Installation is performed in the reverse sequence to the removal

2 - Bolt

- ☐ T 40
- ☐ Torque: 3 Nm
- ☐ 4 units



R66-10070



12.9 Spare wheel support internal cover (2008 ➤) - remove and install

1 - Cover (hinge side)

- ☐ Remove
 - Remove the bolts -2-
- ☐ Install
 - Installation is performed in the reverse sequence to the removal.

2 - Bolt

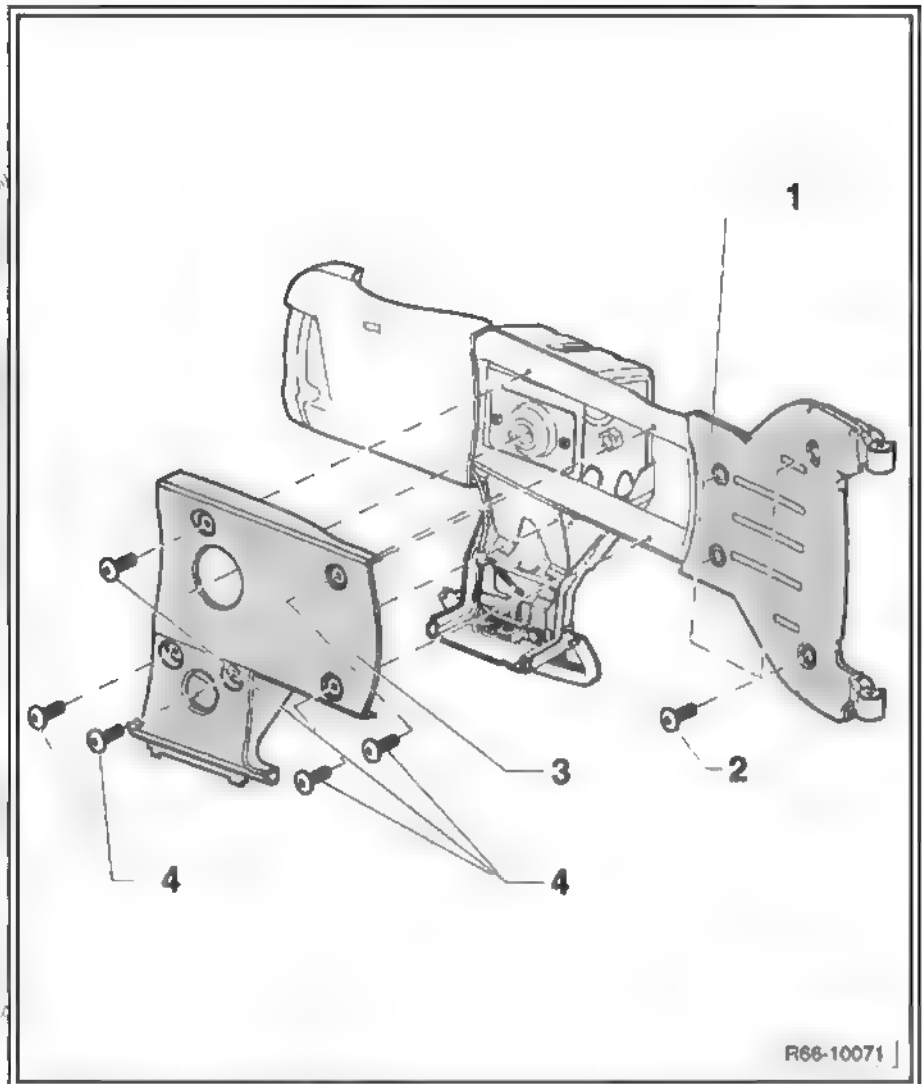
- ☐ T 40
- ☐ Torque: 1.5 Nm
- ☐ 4 units

3 - Cover (lock side)

- ☐ Remove
 - Remove the bolts -4-
- ☐ Install
 - Installation is performed in the reverse sequence to the removal.

4 - Bolt

- ☐ T 40
- ☐ Torque: 1.5 Nm
- ☐ 5 units





12.10 Support unlocking lever cover (2008 ►) - remove and install

1 - Cover (smaller)

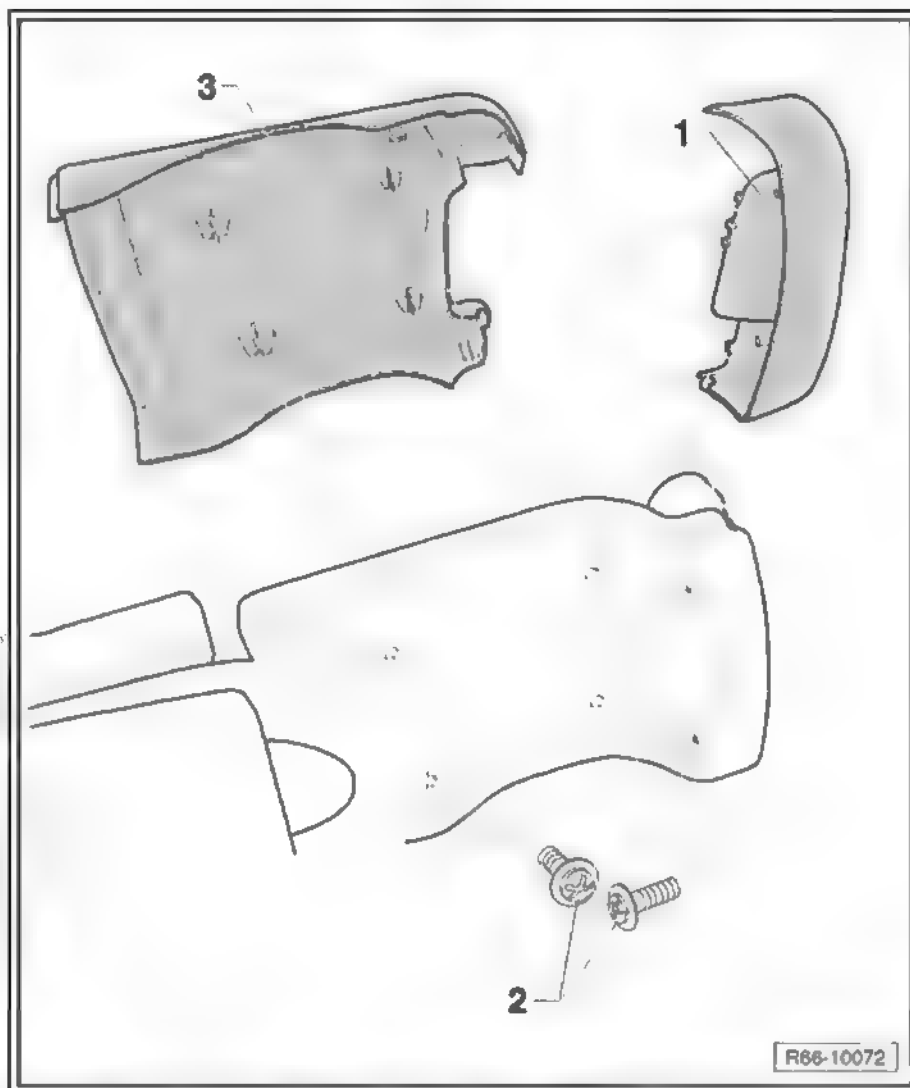
- fitted to spare wheel support and fastened by screws -2-

2 - Bolt

- Torque: 1.5 Nm

3 - Cover (larger)

- fitted to spare wheel support and fastened by screws -2-.



12.11 Support lock activation cable (2008 ►) - remove and install



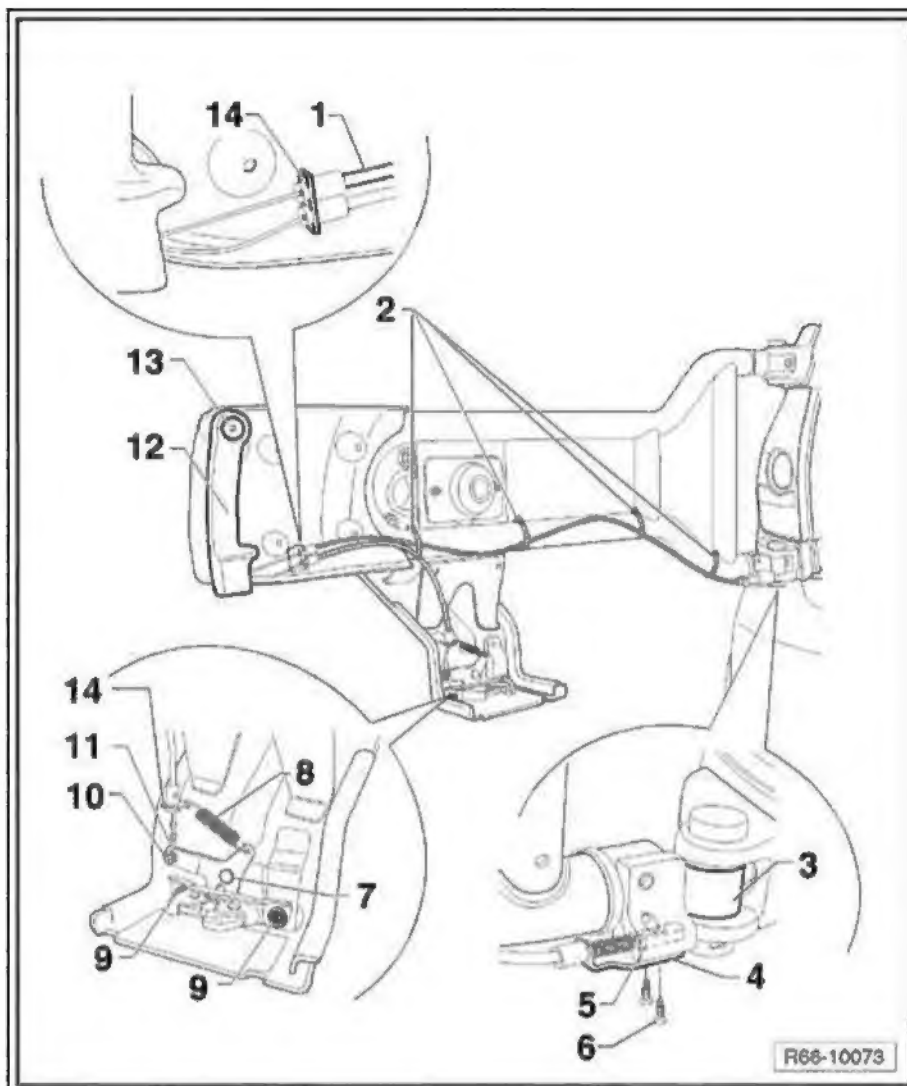
WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual, Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Support lock activation cable

- ☐ Lubricate with special grease - G 000 450 02- .
- ☐ Remove
 - Remove spare wheel.
 - Remove spare wheel support internal cover (lock side and hinge side).
 - Remove support unlocking lever cover (larger and smaller).
 - Remove cable fastening straps -2-.
 - Remove circlip -10- from activation pin -11- of unlocking lever -7-. Disengage support cable -14-.
 - Disengage activation cable from cable support -14- next to activation lever -12-.
 - Disengage activation cable from activation lever -12-.
 - Disengage activation cable from support -4- next to hinge -3-.
 - Disengage activation cable from lock -5-.



- ☐ Install
 - Installation is performed in the reverse sequence to the removal.

2 - Fastening belt

3 - Hinge

- ☐ Lubricate lock housing -5- with special grease - G 000 450 02-.

4 - Cable fastening support on hinge

5 - Retaining clip

- ☐ Lubricate with special grease - G 000 450 02- .
- ☐ to remove it, remove internal cover (hinge side) and remove screws -6-fastening the support -4-. Remove cable -1- from lock.

6 - Bolt

- ☐ Torque: 1.5 Nm

7 - Unlocking lever

8 - Return spring

9 - Bolt

10 - Snap ring

- ☐ replace whenever removed.

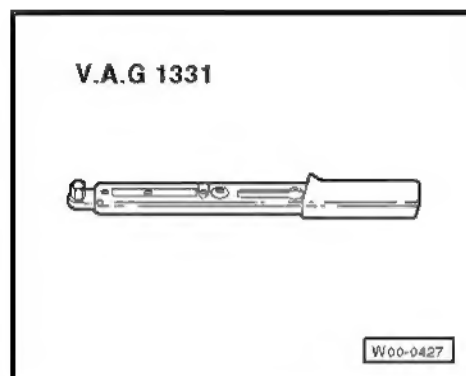


- 11 - Unlocking lever pin
- 12 - Cable activation lever
- 13 - Bolt
- 14 - Cable fastening support

12.12 Spare wheel latch buffer - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





1 - Striker

☐ Remove

- Remove rear protector .
- Disconnect harness connector from Spare wheel support unlocking switch - E540- .
- Remove screws -2- and remove buffer.

☐ Install

- Installation is performed in the reverse sequence to the removal.

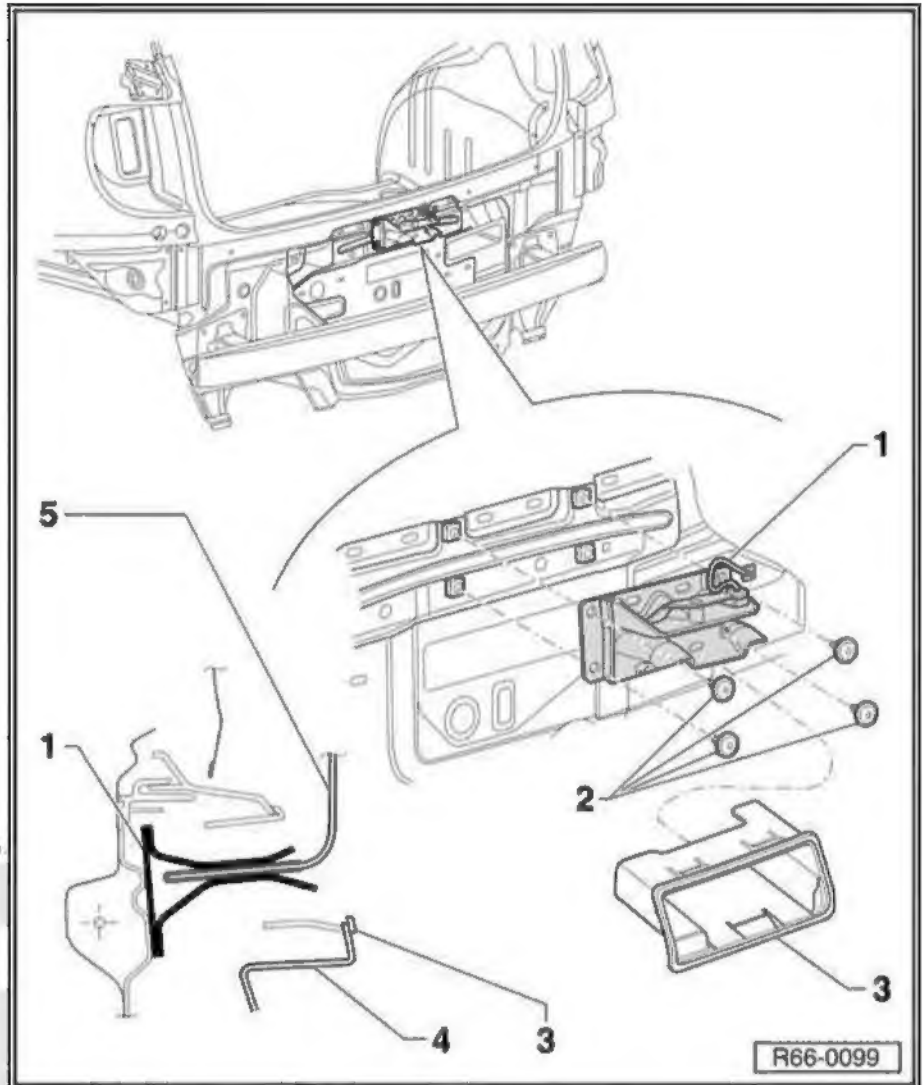
2 - Bolt

- ☐ Torque: 8 Nm

3 - Passage finishing

4 - Bumper rear protector

5 - Spare wheel support





13 Crossfox components

13.1 Assembly overview

1 - Roof rack

- ☐ Remove and install
⇒ [page 197](#)

2 - Spoiler

- ☐ Remove ⇒ [page 185](#)
- ☐ Install ⇒ [page 186](#)

3 - Spare wheel support

- ☐ Remove and install (► 2007) ⇒ [page 278](#)
- ☐ Remove and install (► 2008) ⇒ [page 279](#)

4 - Rear bumper central protection

- ☐ Remove and install
⇒ [page 259](#)

5 - Rear bumper trim

- ☐ Replace ⇒ [page 221](#)

6 - Rear side panel trim

- ☐ Replace ⇒ [page 222](#)

7 - Side footboard rear lining

- ☐ Replace (► 02.06)
⇒ [page 230](#)
- ☐ Replace (03.06 ►)
⇒ [page 238](#)

8 - Side footboard

- ☐ Remove and install (► 02.06) ⇒ [page 225](#)
- ☐ Remove and install (► 03.06) ⇒ [page 232](#)

9 - "CROSSFOX" side inscription

- ☐ On front and rear doors
- ☐ Replace (► 2007) ⇒ [page 219](#)
- ☐ Replace (2008 ►) ⇒ [page 220](#)

10 - Front wing trim

- ☐ Replace ⇒ [page 223](#)

11 - Front bumper trim

12 - Front bumper central protector

- ☐ Remove and install (► 2007) ⇒ [page 256](#)
- ☐ Remove and install (► 2008) ⇒ [page 258](#)

13 - Pillar and door external lining

- ☐ Replace ⇒ [page 265](#)

